

Wednesday, 3/7/2007 4:33:30 PM
Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD ASSEMBLY RH/ DSI 9335
Job Number	: 31083		
Estimate Number	: 12779		
P.O. Number	: <i>N/A</i>	Part Number	: D350600242
This Issue	: 3/7/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D3188, ICA, <i>11N</i>
First Issue	: 3/7/2007	Project Number	: N/A
Previous Run	:	Drawing Revision	: C
		Material	: <i>N/A</i>
Written By	:	Due Date	: 3/30/2007
Checked & Approved By	: <i>07.03.08</i>	Qty:	1 Um: Each
Comment	: Est Rev: A 07.03.07 new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600-141 CHG002

07.03.16

2.0	24083A	SWITCH RELOCATION KIT
-----	-------------------	-----------------------

*B31082A**7/4/559*

Comment: Sub-Component SWITCH RELOCATION KIT

3.0	31083B	SPACEPOD BODY RH
-----	--------	------------------

*D3188 2m*

Comment: Sub-Component SPACEPOD BODY RH

B 30048

P10
See sheet attached
ml 07/03/12

4.0	31083C	SPACEPOD DOOR RH
-----	--------	------------------

*D3186 2m*

Comment: Sub-Component SPACEPOD DOOR RH

*B 30038**(D31864 B31083C)**ml 07/03/12*

5.0	D31872	Spacepod Floor
-----	--------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3187-2	Floor	<i>B 25405 x1</i>
1	D3186-4	Door (ref)	<i>N/A</i>
1	D3188-2	Body (ref)	<i>N/A</i>

ml 07/03/15

6.0	ALS41032430	ALS71030-130	Insert
-----	------------------------	--------------	--------



Comment: Qty.: 28.0000 Each(s)/Unit Total: 28.0000 Each(s)

insert

batch: *M 103495* X 28

D3187-2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 4:33:30 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 31083

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description:

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Transfer drill (#30) from D3187-1 into D3188-1.

2-Open holes in D3188-1 body floor to Ø0.297".

3-Install inserts in D3188-1 as per Dwg D3188.

4-Open holes in D3187-1 aluminum floor to 0.250" per dwg D3187

5-Deburr holes in D3187-1

ml 07/03/15

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EB 07/03/15 ①

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

*****D3187-1 floor only*****

Chemical Conversion Coat as per QSI 005 4.1

sl / m-h 07-03-79 ①

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

*****D3187-1 floor only*****

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

m-h 07/03/20

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 07/03/20

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2004-05

13.0

D2986

Black Neoprene foam .125



Comment: Qty.: 5.9010 sf(s)/Unit Total: 5.9010 sf(s)

neoprene foam

batch:

M 24628

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 31083

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description:

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2986 Neoprene Foam per template D2986T1

m24628

2-Attach Neoprene Foam using Contact Cement

A/R Contact Cement

Batch:

M102565

ml 07/03/21

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

16.0

D2985

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Label

batch: *B 27863* x1

17.0

D30153

Lock Nut



Comment: Qty.: *1.0000* Each(s)/Unit Total: *1.0000* Each(s) *Qty 2*

Lock Nut

batch: *B 30169* x2

18.0

D35471

BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

BRACKET

batch: *B 30636* x1

19.0

D35501

STRUT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

STRUT

batch: *B 31148* x1

20.0

D35547

BALL STUD



Comment: Qty.: *1.0000* Each(s)/Unit Total: *1.0000* Each(s) *Qty 2*

BALL STUD

batch: *B 30210* x2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 31083

Part Number: D350600242

Job Number:



Seq. #:	Machine Or Operation:	Description :
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21.0	D35672	DECAL
------	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) *Qty 2*
DECAL
batch: B 31128

22.0	D2237	Striker Plate
------	-------	---------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Batch: B 30680 *x2*

23.0	MS20426AD45	Rivet
------	-------------	-------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:
Batch: M 102455 *x4*

24.0	D35381	HINGE BRACKET
------	--------	---------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
HINGE BRACKET
batch: B 31123 *x2*

D3538-1 is good ml

25.0	D2179	Doubler
------	-------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Batch: B 21490 *x2*

26.0	AN526C832R24	screw
------	--------------	-------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Screw
batch: M 103574 *x4*

27.0	AN960JD8	Washer
------	----------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Washer
batch: M 102842 *x4*

A 3235-020-935 Washer x8 M100477 *Need these 3 parts.*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 31083

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Qty. 6
Nut
batch: M103538 X6

29.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3187-1 floor with D3188-1 body as per Dwg ICA-D350-600

Hardware on previous steps is for body & floor*

Handwritten: This step is for the floor assembly. m/07/04/02

30.0

D35527

CARBON STEEL GAS SPRING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
CARBON STEEL GAS SPRING
batch: B30638 X1

31.0

MS270390811

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Screw
batch: M103585 X2

32.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Washer
batch: M102842 X4

Handwritten: 2nd for
Cancel this one

33.0

NAS1515H3

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
batch: M100993 X2

34.0

MS21042L08

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Nut
batch: _____

Handwritten: 2nd for
Cancel this one
See Step 28

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 31083

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

D2464

3/4 Seal



Comment: Qty.: 11.3400 f(s)/Unit Total : 11.3400 f(s)

3/4 Seal

Cut 127.00" long batch: B30681

36.0

D35672

DECAL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DECAL

batch: Ø

*2° for
cancel this
one*

37.0

D2586

Door Latch



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Door Latch

batch: B29021 X2

38.0

D2585

Latch Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Latch Clamp

batch: B28019 X2

39.0

D2621

Latch Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Latch Plate

batch: B25903 X2

40.0

MS27039115

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M18057 X2

41.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: M100274 X2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 31083

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

42.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M102217 X2

43.0

D28571

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: B26501 X1

44.0

D28572

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: B26408 X1

45.0

D2228

Backing Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Backing Plate

batch: B31157 (x2) B31237 (x2)

46.0

AN526C832R10

Screw



Comment: Qty.: ~~8.0000~~ Each(s)/Unit Total : ~~8.0000~~ Each(s) Qty 10

Screw

batch: M103585 X10

47.0

AN960JD8

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

batch: M102842 X12

48.0

MS21042L08

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

batch: M103538 X12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 4:33:30 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 31083

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

49.0

D35571

BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET

batch: B30644 X1

50.0

D35547

BALL STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BALL STUD

batch: B30210 X1

~~2 for~~
~~Cancel this one~~

51.0

AN960JD516

Washer

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Qty 2

Washer

batch: m 102929 X2

Need 2 Washers

52.0

D30153

Lock Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lock Nut

batch: B30169 X1

53.0

AN526C832R14

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: m9216 X2

54.0

AN526C832R10

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: Ø

2° for
Cancel this one
See Step 46.

55.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3186-1 door with D3188-1 body as per DWG CA D350-600

Hardware on previous steps is for door ass'y**

Assemble D3186-2 door w/ D3188-6 body per 11N-5350-600
LE 07.03.22

~~This step is not needed~~
mld 07/04/04

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/04/05

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 4:33:31 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 31083

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

56.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/04/05

57.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188 & QSI 005 4.4

Batch: *m103480*

07/03/06

58.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Wing Walk

07/04/05

07/03/06

59.0

*K10021

Spacepod Hardware Kit (-241)



Comment: Qty.: 1.0000 (s)/Unit Total : 1.0000 (s)

B31130

7/4/05

60.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

7/4/05

61.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-600-141

Location: *A*

PPP Rev: *A*

7/4/05

62.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/05

Job Completion



07/04/05

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

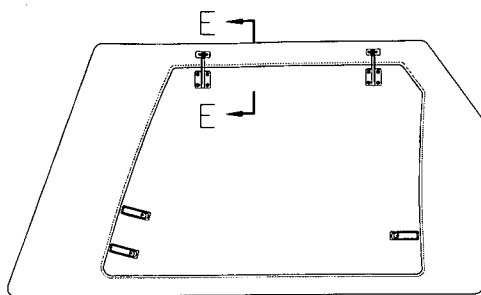


FIGURE 3. LOOKING AT OUTSIDE OF
D350-600-145 DOOR
(D350-600-146 SIMILAR AND OPPOSITE)

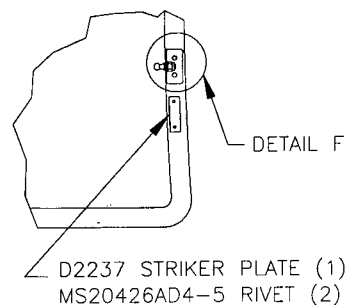


FIGURE 4. TYPICAL DOOR FRAME (AFT EDGE)

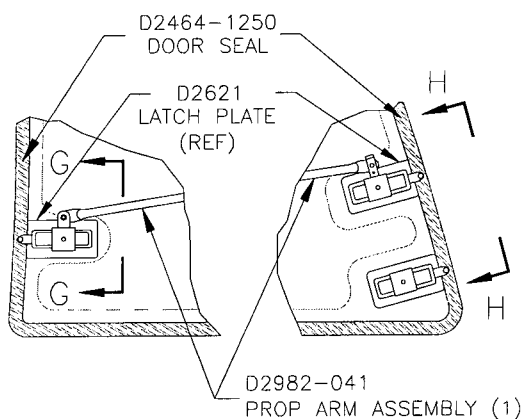
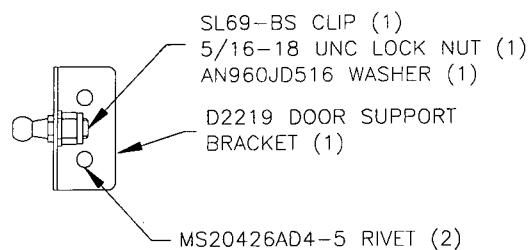


FIGURE 5. LOOKING AT TYPICAL INSIDE
OF D350-600-145/-146 DOOR



DETAIL F

TC Accepted
MAY 07 2003

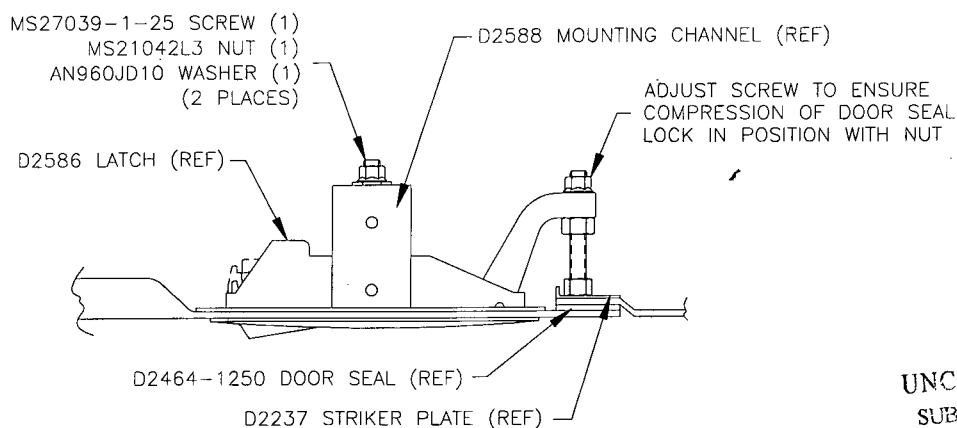
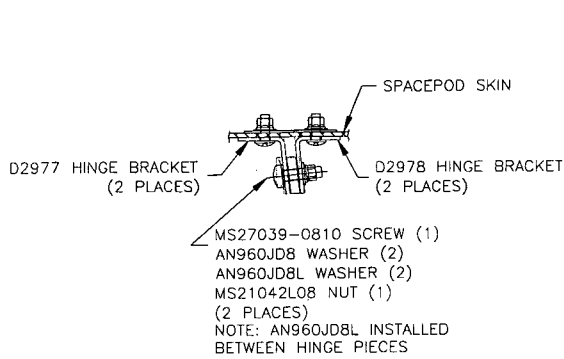


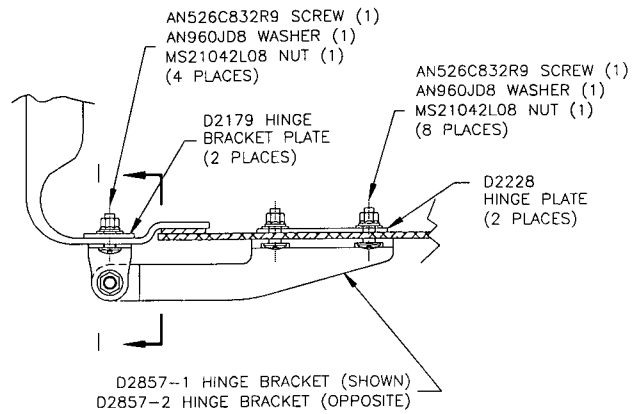
FIGURE 6. TYPICAL LATCH INSTALLATION

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31083

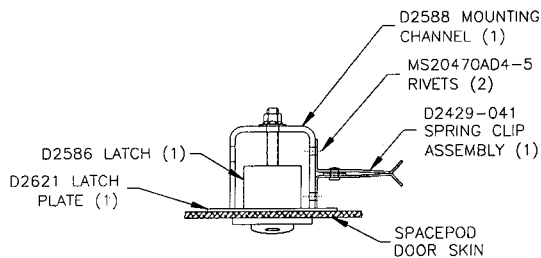
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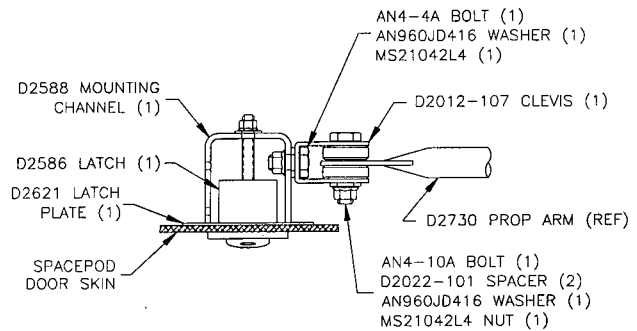
SECTION I-I: HINGE BRACKET



SECTION E-E: HINGE DETAIL FROM FIGURE 3



SECTION H-H: FWD LATCH



SECTION G-G: AFT LATCH

25.3 SPACEPOD™ REMOVAL

1. Remove D350-600-045/-145 or -046/-146 door.
2. Remove battery shelf and wiring covers as applicable.
3. Loosen floor and D2174-041 bracket fasteners shown in section A-A, B-B, and C-C of Figure 2. Leave inserts in the compartment floor.
4. Remove **Spacepod™** body from the compartment.
5. Remove D2174-041 brackets.
6. Re-install battery shelf and wiring covers.
7. Re-install outboard tiedown "D" rings.
8. Re-install door latch tiedown brackets in the compartment floor.
9. Re-install baggage retaining net.
10. Re-install original side baggage compartment door.

TC Accepted

MAY 07 2003

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25-00-00

DART

RELEASED

07.02.22

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
JB	CE	DRAWING NO.	REV. D
CHECKED	APPROVED	D3188	SHEET 1 OF 11
DATE		TITLE	SCALE
07.02.22		SPACEPOD BODY	NTS
A	03.04.03	NEW ISSUE	
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

GENERAL NOTES:

- REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

- MOLD SHEDULE:

PART
D3188-1M/-1/-5
D3188-2M/-2/-6
D3188-3M/-3/-7

LAYUP
DT8003
DT8004
DT8500

TRIM AND DRILL
DT8501
DT8502
DT8501

- APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE

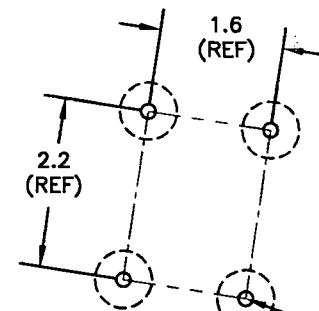
WORK ORDER

NO 31083

DART

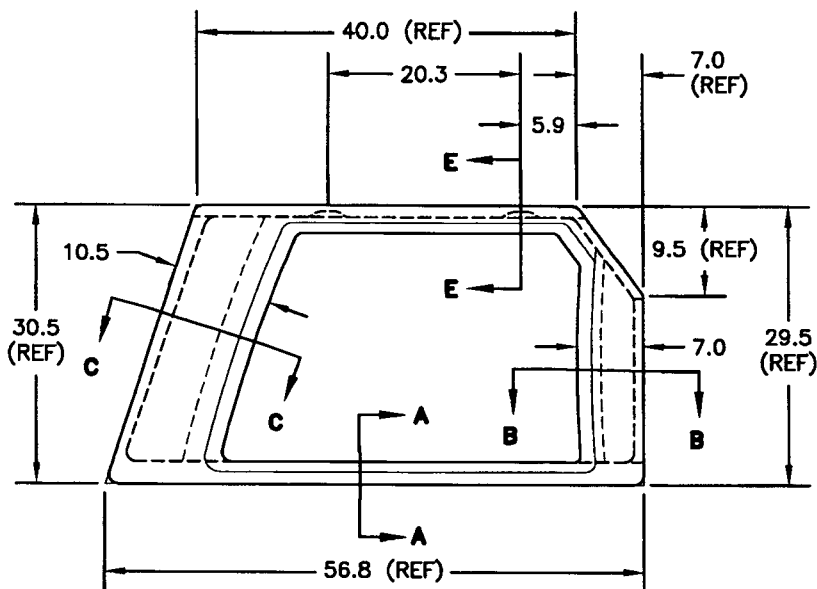
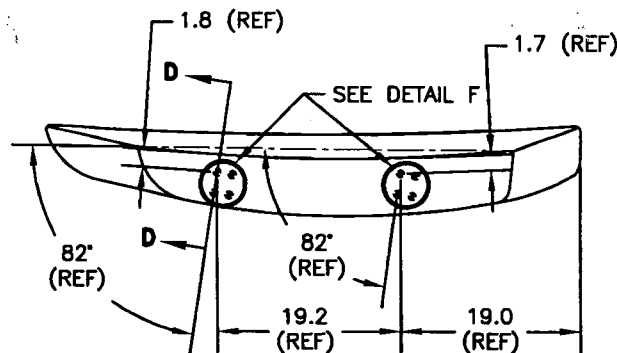
RELEASED
07.02.22

DESIGN JB	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>JB</i>	APPROVED <i>JB</i>	DRAWING NO. D3188
DATE 07.02.22	TITLE SPACEPOD BODY	REV. D SHEET 2 OF 11
	SCALE NTS	

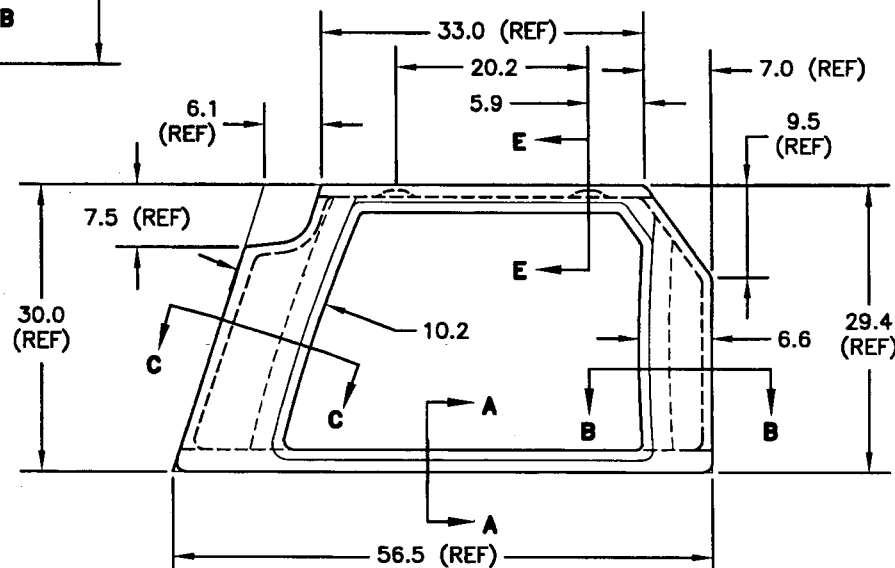
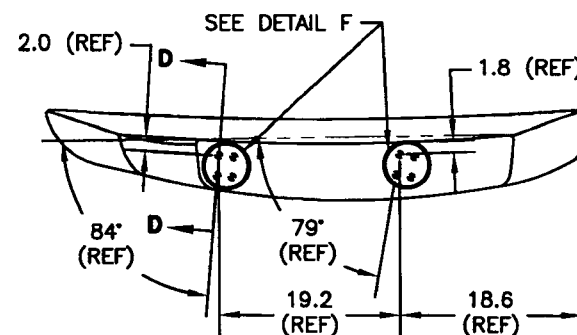


DETAIL F

INSTALL
D2213 SPACER
(8 PLACES)
(SEE SECTION D-D)



D3188-1M SPACEPOD BODY



D3188-3M SPACEPOD BODY

D3188-1M/-3M NOTES:

1. REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
2. SEE SHEET #4 FOR SECTION VIEWS.

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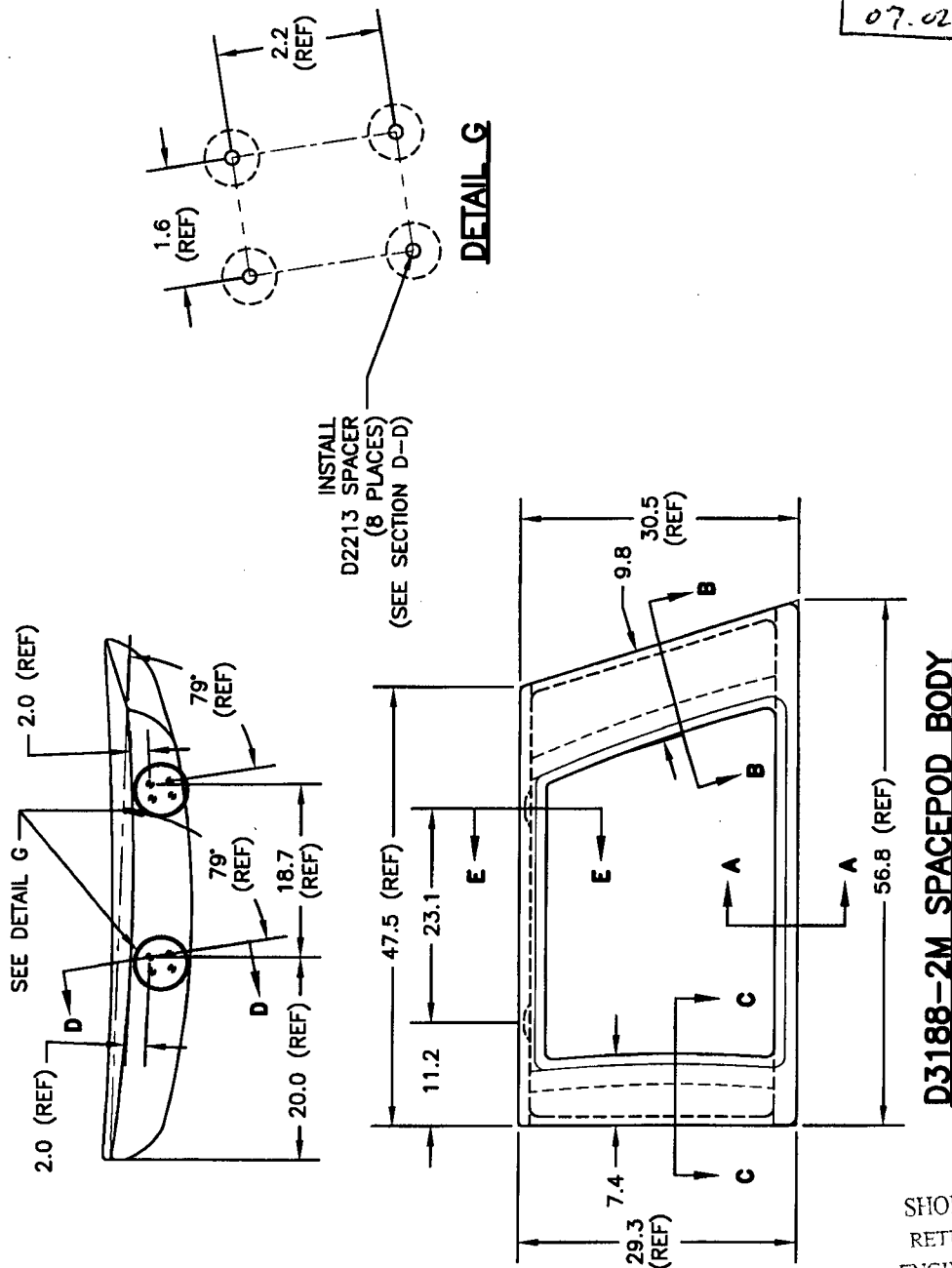
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DART

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CHECKED JB	APPROVED [Signature]	DRAWING NO. D3188	REV. D SHEET 3 OF 11
DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.02.27



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31083

D3186-2M NOTES:
1. REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
2. SEE SHEET #4 FOR SECTION VIEWS.

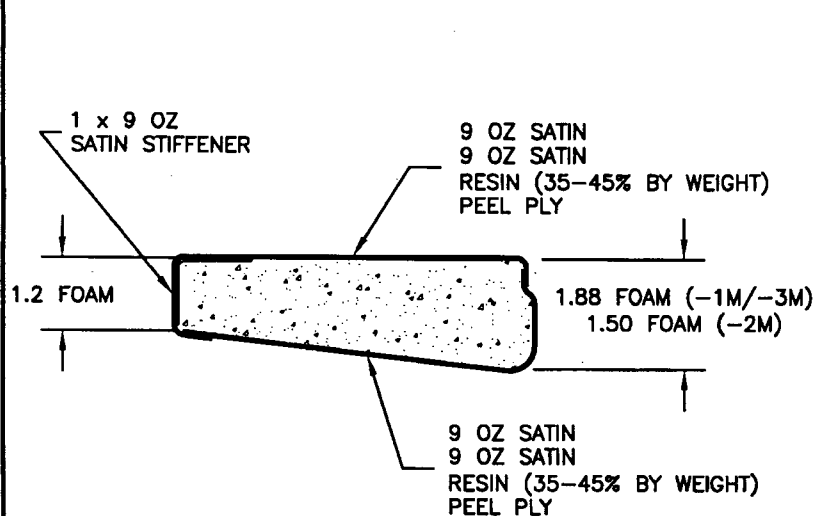
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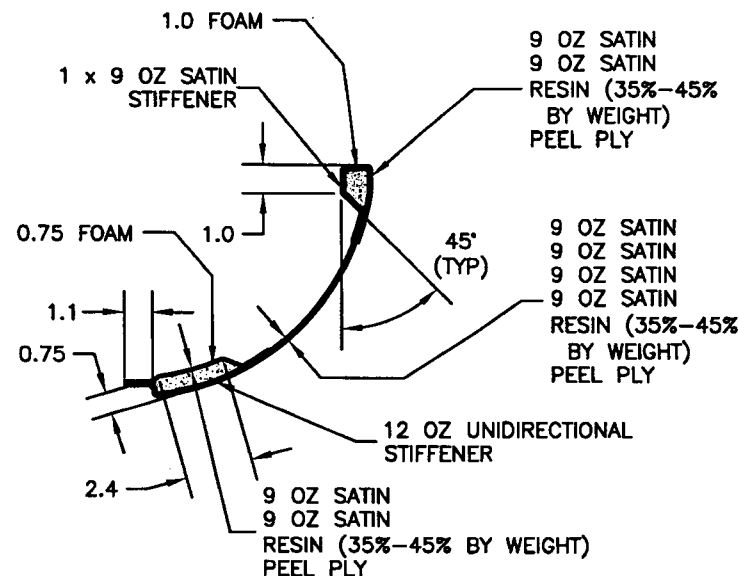


DESIGN	JB	DRAWN BY	CE	DART AEROSPACE LTD
CHECKED	JB	APPROVED	JB	HAWKESBURY, ONTARIO, CANADA
DATE	07.02.22	TITLE	D3188	REV. D
			SPACEPOD BODY	SHEET 4 OF 11
				SCALE
				NTS

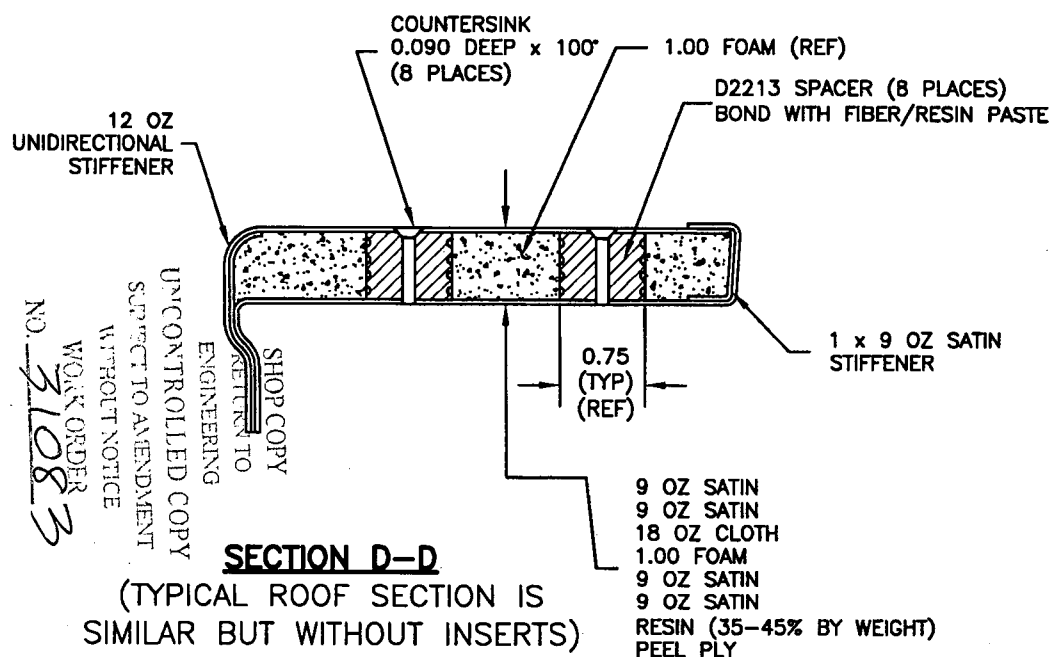
RELEASED
07.02.27



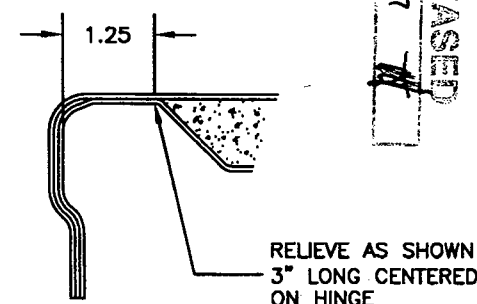
SECTION A-A
(TYPICAL FLOOR SECTION)



SECTION B-B
(SECTION C-C OPPOSITE)



SECTION D-D
(TYPICAL ROOF SECTION IS
SIMILAR BUT WITHOUT INSERTS)



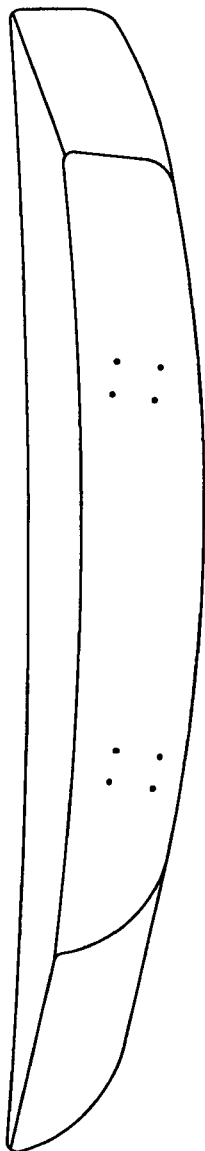
SECTION E-E
(2 PLACES PER POD)



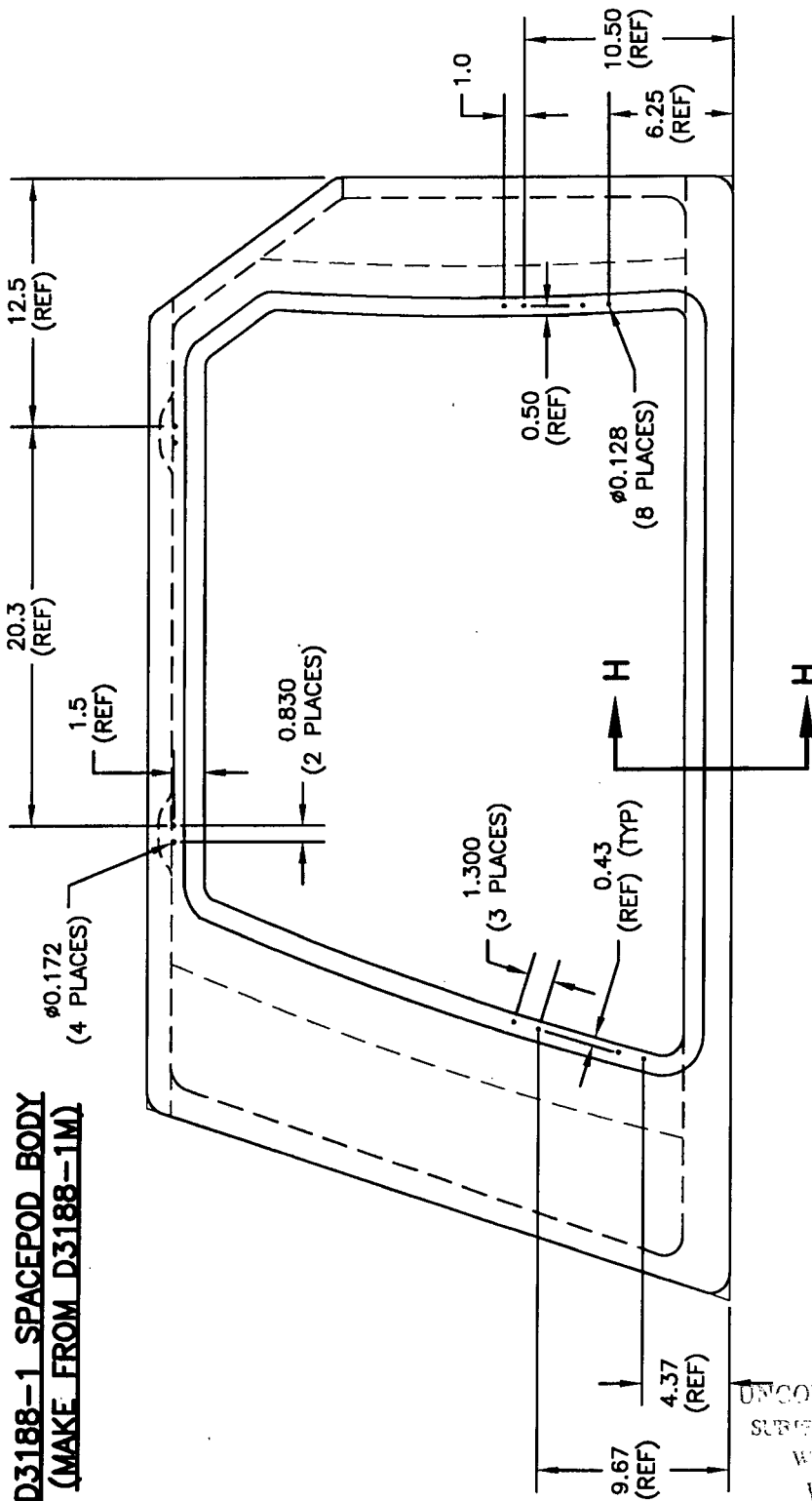
DESIGN JB	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3188	REV. D SHEET 5 OF 11
DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07-02-27 [Signature]



**D3188-1 SPACEPOD BODY
(MAKE FROM D3188-1M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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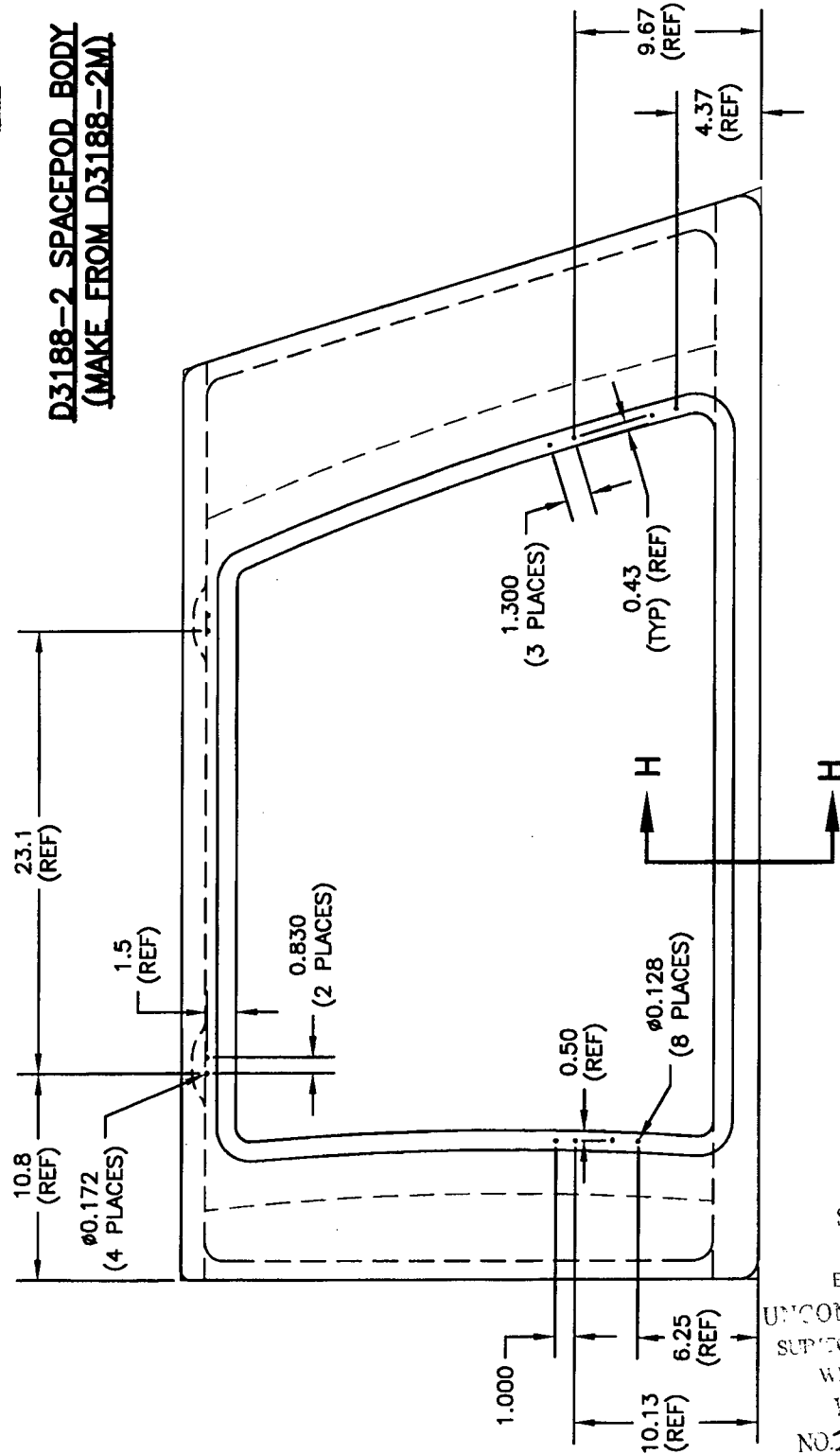
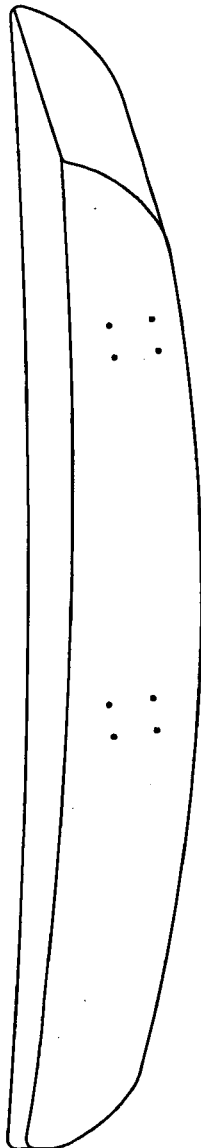
DART

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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3188	REV. D SHEET 6 OF 11
DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.02.27

**D3188-2 SPACEPOD BODY
(MAKE FROM D3188-2M)**



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1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEW

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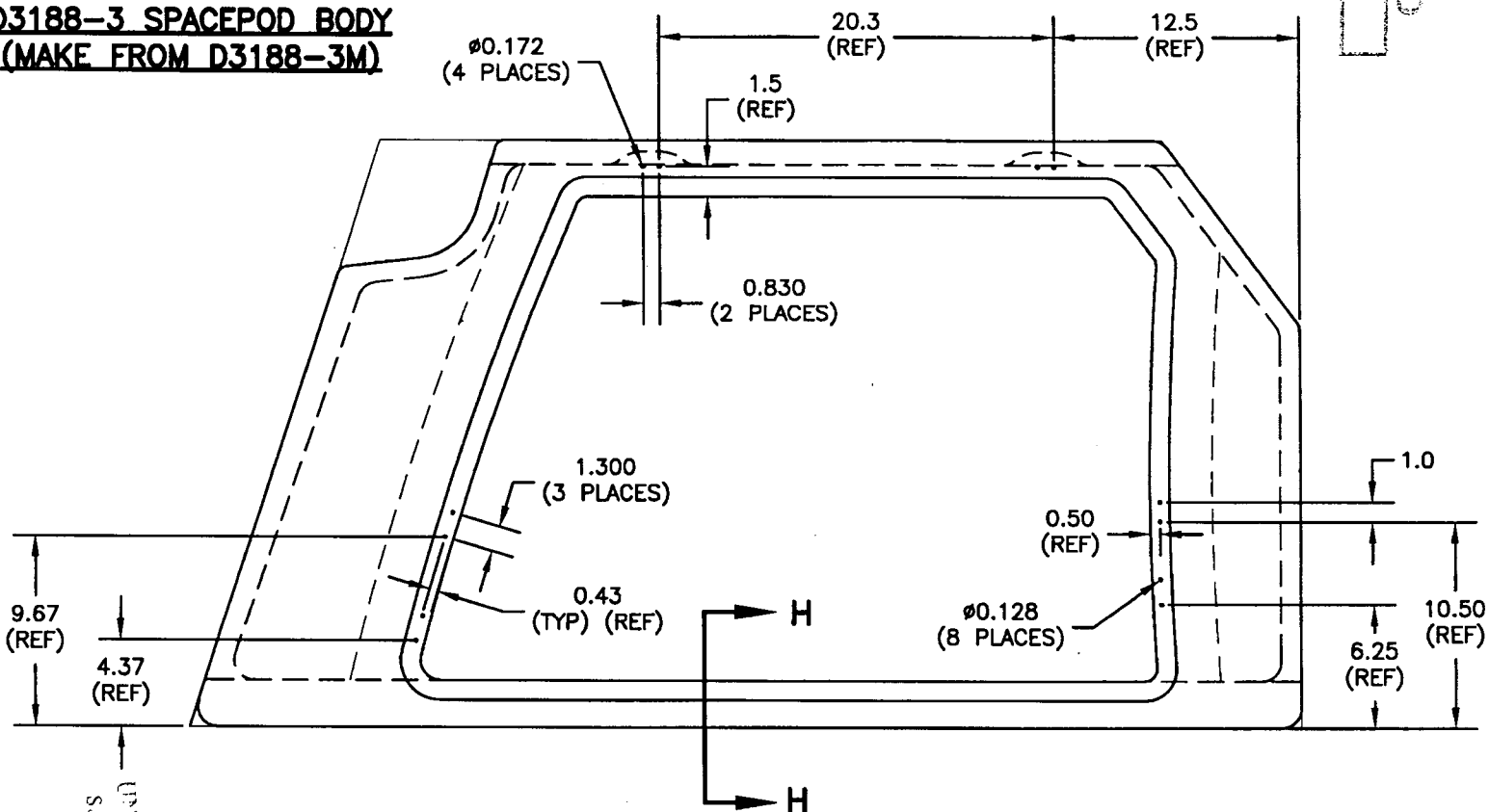
DART

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JB	CE	DRAWING NO.	REV. D
CHECKED	APPROVED	D3188	SHEET 7 OF 11
DATE		TITLE	SCALE
07.02.22		SPACEPOD BODY	NTS

RELEASED

07.02.27

**D3188-3 SPACEPOD BODY
(MAKE FROM D3188-3M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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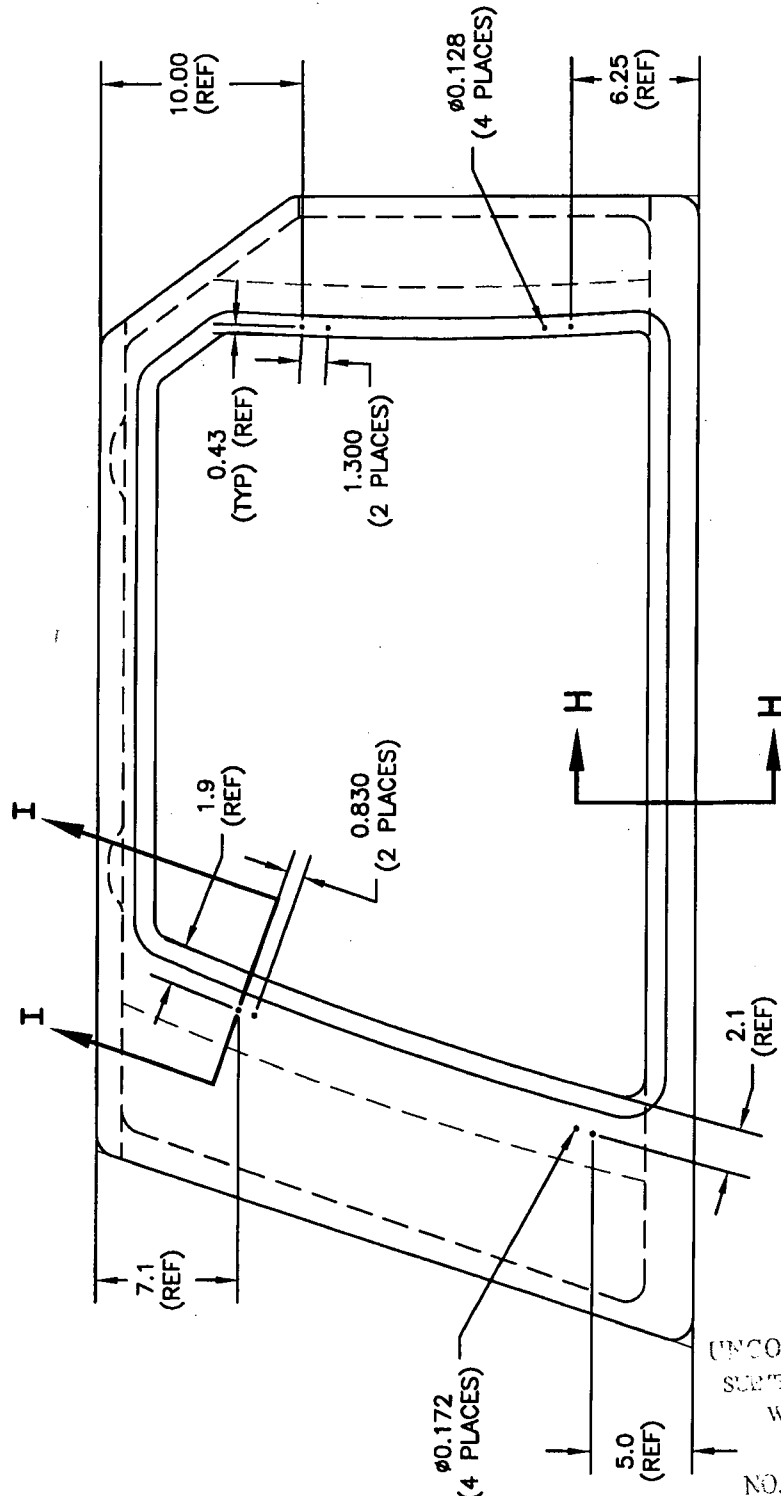
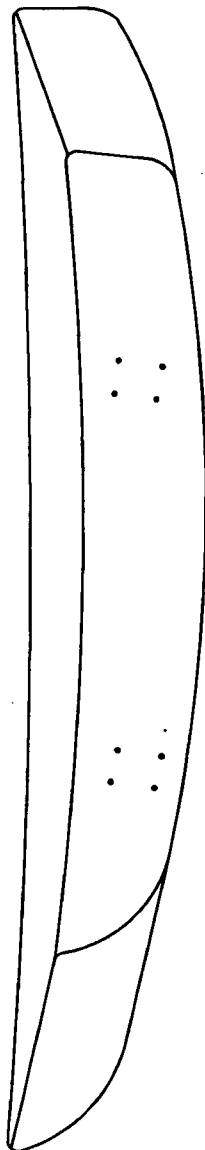
DART

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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3188	REV. D SHEET 8 OF 11
DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.02.27 [Signature]

D3188-5 SPACEPOD BODY
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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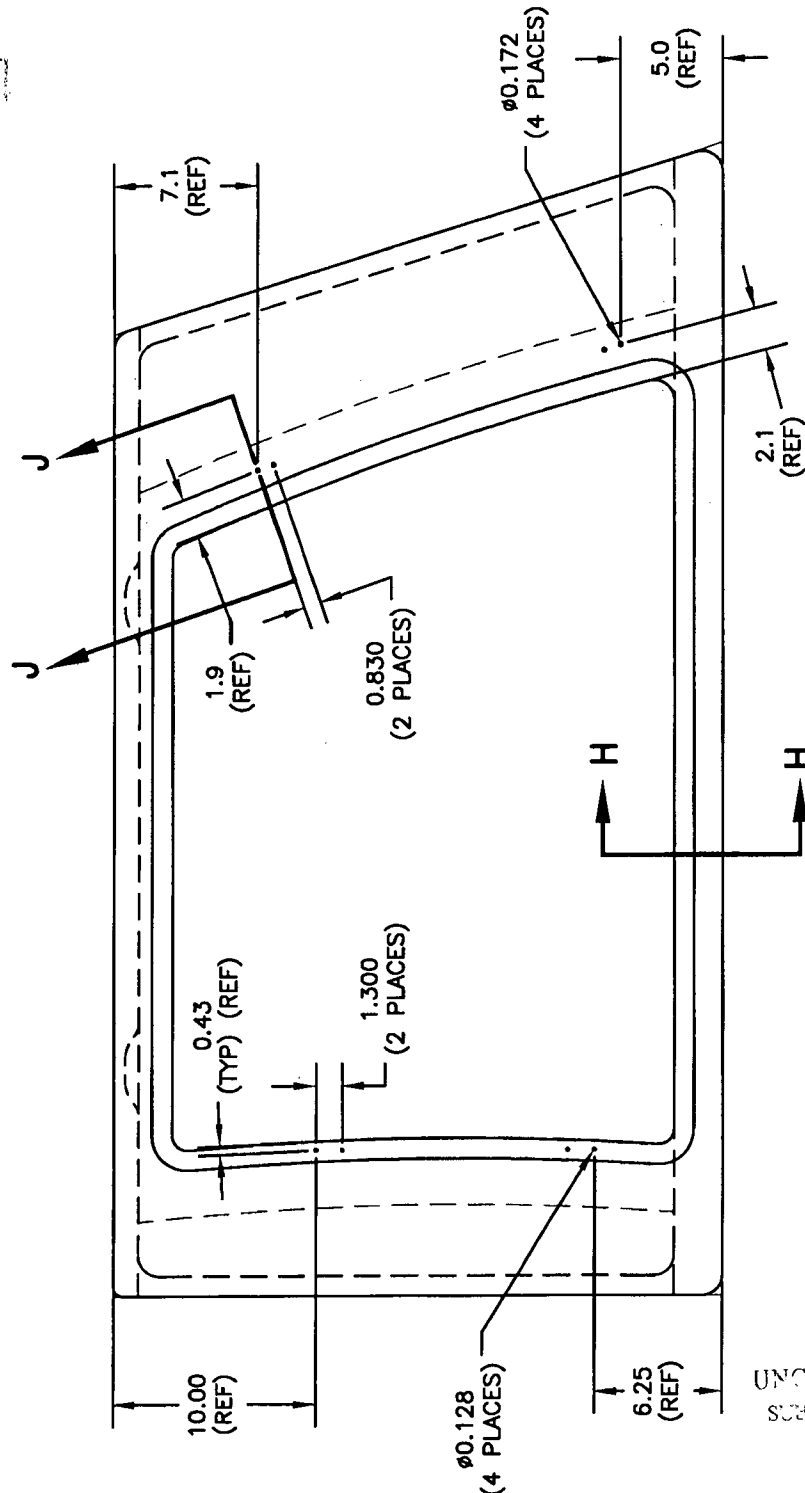
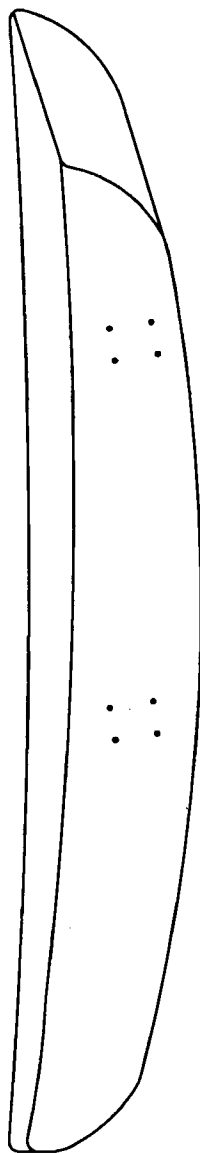
DART

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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3188	REV. D SHEET 9 OF 11
DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.02.27

**D3188-6 SPACEPOD BODY
(MAKE FROM D3188-2M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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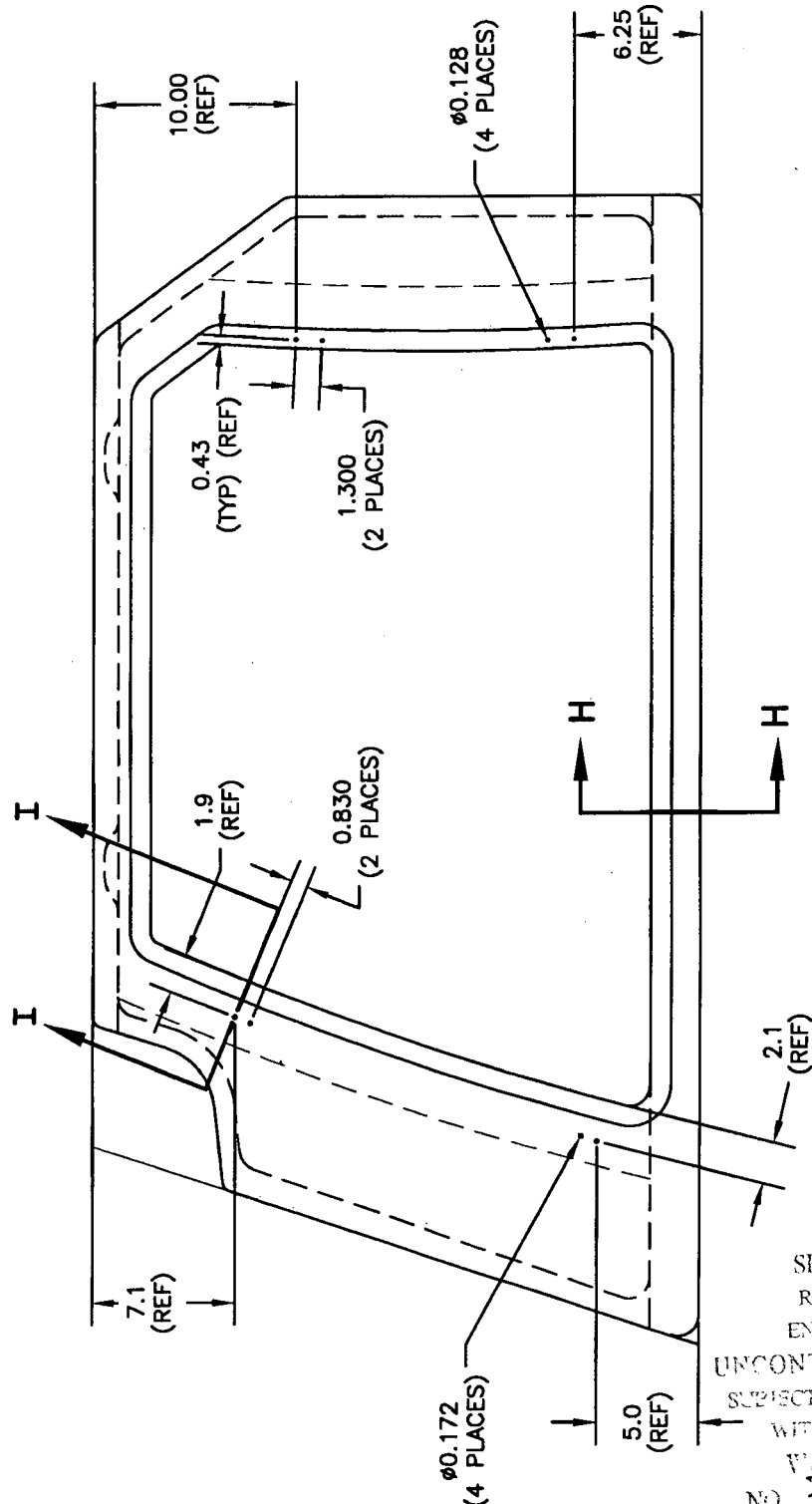
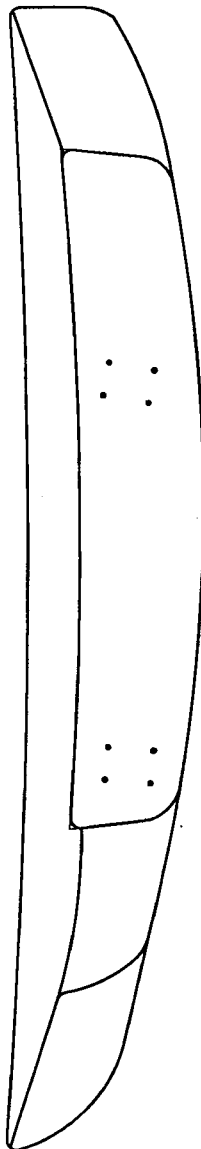
DART

DESIGN JB	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3188	REV. D SHEET 10 OF 11
DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07-02-22

D3188-7 SPACEPOD BODY
(MAKE FROM D3188-3M)



NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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Thursday, 12/10/2006 11:10:57 AM
Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.
Job Number : 00065A
Estimate Number : 10068
P.O. Number :
This Issue : 12/10/2006 S.O. No. :
Prsht Rev. : NC
First Issue : 12/07/2006 Type : R&D MACHINED PARTS
Previous Run : 00064A
Drawing Name : INITIAL PROTOTYPE TEMPLATE
Part Number : INITIAL PROTOTYPE
Drawing Number :
Project Number : N/A
Drawing Revision :
Material :
Due Date : 28/06/2006 Qty: 1 Um: Each
Written By :
Checked & Approved By :
Comment : Project #:
Description:

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

MFG ENGINEERING

MFG ENGINEERING



Comment: MFG ENGINEERING

Manufacture Prototype as per Dwg's Supplied By Engineering

Comments:

-Fill .375 holes with hysol 934NA A/B B M101268B M101268Add milled fibre B 100859 10% by weight

Repair holes IAW IIN D350-600 para 3.4.9

06/10/02

PTO 1

Re do for Space pod R/H
w/o 31083

Hysol 934 ~~M101268~~ M103922

milled fiber M100859 10% by weight

PTO 2

Made Holes Bad Position. Fill them with
Hysol M103922 and
milled fiber M100859

ml 07/03/21

ml 07/03/29

DART

DESIGN JB	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JB	APPROVED [Signature]	DRAWING NO. D3188	REV. D SHEET 11 OF 11
DATE 07.02.22		TITLE SPACEPOD BODY	SCALE NTS

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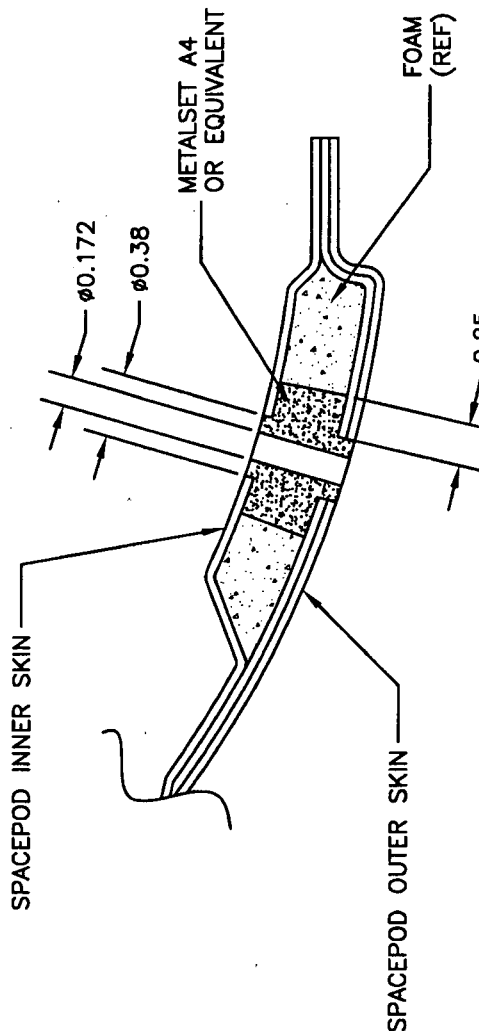
07.02.27

INSTALL AKS7-1032-130
INSERTS (29 PLACES)
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)

FOAM
(REF)



SECTION H-H
(TYPICAL FLOOR SECTION)

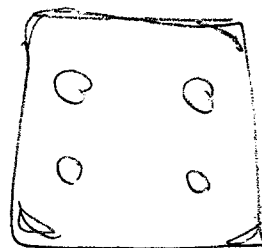


SECTION I-I
(SECTION J-J OPPOSITE)
(4 PLACES PER POD)

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Leanne Elsliger

From: David Shepherd [dshepherd@dartaero.com]
Sent: March 21, 2007 3:55 PM
To: 'Leanne Elsliger'
Cc: 'S Shahbazian'
Subject: RE: Metalset A4

It is acceptable to substitute the Hysol 934NA for the Metalset A4 on the -241/-242 Spacepods. Please update D3188 to make this a permanent change.

David

From: Leanne Elsliger [mailto:lelsiger@dartaero.com]
Sent: Wednesday, March 21, 2007 11:54 AM
To: 'David Shepherd'
Cc: 'S Shahbazian'
Subject: Metalset A4

Hi David –

Per work orders 31078 and 31083, the -241/-242 Spacepod kits are being assembled. To install the D3538-1 hinge brackets, 3/8" holes are drilled and filled with Metalset A4 or equivalent per D3188 rev D. For the test, we used Hysol 934NA mixed with milled glass fibers as the 'equivalent'. In the IIN, we give the option of Metalset A4 or Hysol 934NA w/ milled glass fibers. For these w/o's please provide approval to use Hysol 934NA with milled glass fibers as the 'equivalent'.

Thanks,
Leanne

Leanne Elsliger, P.Eng
Design Engineer
Dart Aerospace Ltd.
1270 Aberdeen St.
Hawkesbury, ON, K6A 1K7
T: (613) 632-5200
F: (613) 632-9311

--
No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.1.413 / Virus Database: 268.18.16/729 - Release Date: 3/21/2007

--
No virus found in this outgoing message.
Checked by AVG Free Edition.
Version: 7.1.413 / Virus Database: 268.18.16/729 - Release Date: 3/21/2007

22/03/2007

Date: Wednesday 3/7/2007 4:30 PM
 User: Kim Johnston

Process Sheet

13

Customer: CU-DAR001 Dart Helicopters Services Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335
 Job Number: 31083
 Estimate Number: 12779
 P.O. Number:
 This Issue: 3/7/2007 S.O. No.:
 Prsht Rev: NC
 First Issue: 3/7/2007 Type: SMALL /MED FAB
 Previous Run:
 Written By:
 Checked & Approved By: 07.03.08
 Comment: Est Rev.A 07.03.07 new issue EC

Part Number: D350600242
 Drawing Number: D3188,ICA
 Project Number: N/A
 Drawing Revision: C
 Material:
 Due Date: 3/30/2007 Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600-242 CHG002

07.03.16

2.0 31083A SWITCH RELOCATION KIT



Comment: Sub-Component SWITCH RELOCATION KIT

3.0 31083B SPACEPOD BODY RH



Comment: Sub-Component SPACEPOD BODY RH

4.0 31083C SPACEPOD DOOR RH



Comment: Sub-Component SPACEPOD DOOR RH

5.0 D31872 Spacepod Floor



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3187-2 Floor

1 D3186-4 Door (ref)

1 D3188-2 Body(ref)

6.0 ALS41032130 Insert



REFERENCE ONLY



Comment: Qty.: 28.0000 Each(s)/Unit Total: 28.0000 Each(s)

insert

batch:



DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	11645
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
28/02/07	21/12/06	5092	C. Lavoie		PO00002767		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0053	D3188-1M Spacepod Body LH B30028 Dwg. Rév.: C Job: 40968 U de M : Each			
1	0	1	DKC134-0055	D3188-2M Spacepod Body RH B30048 Dwg. Rév.: C Job: 40970 U de M : Each			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

Quality department



28/2/07

AQ-357

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Vendredi, 2007-02-09 09:14:51
 Utilisateur: Marc Dubé

Feuille de Procédé

Client	: DART	Dart Aerospace Ltd.	Nom Dessin	: SPACEPOD BODY	R / H
Numéro Job	: 40970		Numéro Article	: DKC134-0055	
Numéro Soumission	: 2587		Numéro Dessin	: D3188	
Numéro B.A.	:		Projet Numéro	: DKC134	
Cette fois	: 2007-02-09	No. B.V. :	Révision dessin	: 	
Prsht Rev.	: NC		Matériel	: Fibre 7781 et Résine 411-350	
Prem. fois	: - -	Type :	Date Dûe	: 2007-02-16	Qté: 1 Udm: UNITE
Job précédente	: 40969				
Écrit par	:				
Vérifié & Approuvé par	:				
Commentaires	:	N° de pièce Dart Aerospace : D31882M N° de Projet Delastek: DK-362			

 Process Sheet Rev.: 00 Création du premier à partir du
 DKC134-0020

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

1.0	AC0303	Frekote 44NC
-----	--------	--------------

Commentair Qty.:	0.050 UNITE(s)/Unit	Total :	0.050 UNITE(s)
Frekote 44NC			

2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
-----	---------------	------------------------------



Commentair Setup:	0.00Hrs/ Run:	5.0000Min	Total Run :	0.0833Hrs
PRÉPARATION DU MOULE				

Faire la préparation du moule N° DT 8004 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.

 Date: 25-01-07 Heure Début: _____ Heure Fin: _____ Sceau: DR

3.0	AC0409	Tissu à délaminer Release ply B
-----	--------	---------------------------------

Commentair Qty.:	9.84 VERGE(s)/Unit	Total :	9.84 VERGE(s)
Tissu à délaminer Release ply B			

4.0	AC0407	Wrightlon 5200 Bleu P3
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Commentair Qty.:	9.27 VERGE(s)/Unit	Total :	9.27 VERGE(s)
Wrightlon 5200 Bleu P3			






5.0	AC0408	Feutre de drainage N° Airweave N 10
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Commentair Qty.:	6.00 VERGE(s)/Unit	Total :	6.00 VERGE(s)
Feutre de drainage N° Airweave N 10			

6.0	AC0752	Stretchlon 200 poche à vide Vert
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Commentair Qty.:	7.00 VERGE(s)/Unit	Total :	7.00 VERGE(s)
Stretchlon 200 poche à vide Vert			

Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY	
Numéro Job: 40970		Numéro Article: DKC134-0055	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
7.0	AAC0326	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish	
Commentaire Qty.: 11.4 VERGE(s)/Unit Total : 11.4 VERGE(s) 9.7 oz 7781 Weave "S" glass #FG-778150-125Y N° de Lot: <u>1-5905-1</u>			
8.0	AAC0443	Fiberglass 12 oz Unidirectional	
Commentaire Qty.: 0.80 VERGE(s)/Unit Total : 0.80 VERGE(s) Fiberglass 12 oz Unidirectional N° de Lot: <u>1-5455-1</u>			
9.0	AAC0633	WR1850 ROVING 18 OZ x 50"	
Commentaire Qty.: 0.35 VERGE(s)/Unit Total : 0.35 VERGE(s) WR1850 ROVING 18 OZ x 50" N° de Lot: <u>1-5873-1</u>			
10.0	AC0098	Ruban à gommer jaune #: T/AT-200Y	
Commentaire Qty.: 4.0000 RL(s)/Unit Total : 4.0000 RL(s) Ruban à gommer jaune #: T/AT-200Y			
11.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
Commentaire Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs TAILLAGE DU MATÉRIEL Tailler le matériel, selon les différents patrons de découpe et les quantités inscrites sur ceux-ci. À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres. Date: <u>25-01-07</u> Heure Début: _____ Heure Fin: _____ Sceau: <u>HG</u>			
12.0	AAC0275	Catalyst N° DDM-9	
Commentaire Qty.: 0.0640 PINTE(s)/Unit Total : 0.0640 PINTE(s) Catalyst N° DDM-9 N° de Lot: <u>5921</u>			
13.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
Commentaire Qty.: 2.000 KILOGRAMME(s)/Unit Total : 2.000 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-5966-1</u>			
14.0	AAC0673	Fibre de verre Miapoxy 66	
Commentaire Qty.: 0.0039 GALLON(s)/Unit Total : 0.0039 GALLON(s) Fibre de verre Miapoxy 66 N° de Lot: <u>1-5502-1</u>			
15.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MATÉRIEL Faire la préparation de la résine selon les quantités requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.			

Date: Vendredi, 2007-02-09 09:14:51

Utilisateur: Marc Dubé

Feuille de Procédé

Cliant: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 40970

Numéro Article: DKC134-0055

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Préparer une seringue de 30 ml de résine chargée de fibre de verre miapoxy 66

26-01-07

Date: _____ Heure Début: _____ Heure Fin: _____ Sceau: DR

16.0

LAMINAGE.

LAMINAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs

FAIRE LE LAMINAGE DES TISSUS

À l'aide de la seringue, faire un joint tout le tour de la dénivellation pour la porte directement dans le moule.

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8004 et ensuite imbiber un pli de tissu 9.7oz. et 18 oz. sur la section supérieur de la pièce.

Laminage du 12 oz.

Recommencer l'opération pour le deuxième pli.

26-01-07

Date: _____ Heure Début: _____ Heure Fin: _____ Sceau: DR CG SL

17.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

26-01-07

Date: _____ Heure Début: _____ Heure Fin: _____ Sceau: DR CG SL

Curing Début: _____ Curing Fin: _____

18.0

AAC0457

ATC core-cell A500 plain 4'x8' 1" thick








Commentaire Qty.: 0.75 FEUILLE(s)/Unit Total : 0.75 FEUILLE(s)

ATC core-cell A500 plain 4'x8' 1" thick Selon dessin D3188 de Dart

N° de Lot: L-5836-1

Date: Vendredi, 2007-02-09 09:14:51
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY	
Numéro Job: 40970		Numéro Article: DKC134-0055	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
19.0	FAB GÉNÉRALE 3	FABRICATION GÉNÉRALE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs TAILLAGE DU MATÉRIEL Tailler le Foam Core 1" selon le plan de découpe et les gabarits <u>29-01-07</u> Date: _____ Heure Début: _____ Heure Fin: _____ Sceau: <u>DR</u>			
20.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
Commentaire Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-5957-2</u>			
21.0	AAC0275	Catalyst N° DDM-9	
Commentaire Qty.: 0.0064 PINTE(s)/Unit Total : 0.0064 PINTE(s) Catalyst N° DDM-9 N° de Lot: <u>5921</u>			
22.0	FINITION 3	FINITION PIÈCE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs FINITION PIÈCE DART Prendre les deux pièces de 11" x 57" et sceller la grande surface sur chacune d'elle selon I.G. # Sceller le Foam Core. <u>29-01-07 DR</u>			
23.0	AAC0452	Polybond B46F	
Commentaire Qty.: 0.010 KIT(s)/Unit Total : 0.010 KIT(s) Polybond B46F N° de Lot: <u>1-5865-1</u>			
24.0	FINITION 3	FINITION PIÈCE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs FINITION PIÈCE DART À l'aide du Polybond, coller ensemble les deux surfaces scellées Disposer des poind sur les pièces pour conserver une pression de collage. Laisser sécher pour un minimum de deux heures. Quantité: <u>1</u> Date: <u>29-01-07</u> Sceau: <u>DR</u>			

Date: Vendredi, 2007-02-09 09:14:51

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40970

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

Quantité: _____ Date: _____ Sceau: _____

25.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
TRIMAGE COMPOSITES DART

Ajuster chacune des pièces de foam core dans le moule selon de lessin.

Quantité: 1 Date: 29-01-07 Sceau: DR

Quantité: _____ Date: _____ Sceau: _____

26.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-5957-2

27.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0096 PINTE(s)/Unit Total : 0.0096 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5921

28.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Hrs Total Run : 10.0000Hrs
PRÉPARATION DU MATÉRIEL DART

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par
quantité de résine N° 411-350 promu 75 minutes.. 29-01-07 DR

29.0

FAB GÉNÉRALE 3

FABRICATION GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 20.0000Hrs Total Run : 20.0000Hrs
FABRICATION GÉNÉRALE PLASTIC COMMERCIAL

Retirer les pièces de foam core du moule

Sceller les foam core à l'aide de la résine promu N° 411-350 75 minutes. Selon I.G.# Sceller le foam Core.

Laisser sécher pendant 2 heures minimum.

Date: 29-01-07 Sceau: _____ Initiales: DR

Date: Vendredi, 2007-02-09 09:14:52

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 40970

Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

30.0 AAC0452 Polybond B46F

Commentaire Qty.: 0.078 KIT(s)/Unit Total: 0.078 KIT(s)

Polybond B46F N° de Lot: 1-5865-1

31.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation du Poly bond.

Date: 30-01-07 Heure Début: _____ Heure Fin: _____ Sceau: DR CG

32.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART

Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run: 1.0000Hrs
ASSEMBLAGE GÉNÉRALE DES PIÈCES

Coller les différents pièces de Foam Core dans les Spacepod Body à l'aide du Poly bond.

Date: 30-01-07 Heure Début: _____ Heure Fin: _____ Sceau: DR SV CG

33.0 POCHÉ À VIDE 1 FAIRE LA POCHÉ À VIDE

Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run: 0.3333Hrs
EFFECTUER LA POCHÉ A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum.

Retirer le bagging entre 1 heure et 1 heure 1/2 après le mélange de la résine afin d'enlever le surplus de polybond avant que celui-ci ne soit complètement polymérisé.

Date: 30-01-07 Heure Début: _____ Heure Fin: _____ Sceau: DR SV CG

Curing Début: _____ Curing Fin: _____

Date: Vendredi, 2007-02-09 09:14:52

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40970Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

34.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentaire Qty.: 0.100 UNITE(s)/Unit Total : 0.100 UNITE(s)
Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-5957-1

35.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentaire Qty.: 0.078 UNITE(s)/Unit Total : 0.078 UNITE(s)
Durcisseur Polysoft #004009 Sikkens

36.0 FINITION 3 FINITION PIÈCE DART

Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
FINITION GÉNÉRALE

Corriger les petits défauts de surface de la pièce avec du Sikkens. Pour les plus gros défauts utiliser du polybond

Date: 31-01-07 Heure Début: Heure Fin: Sceau: DR

37.0 TRIMAGE 3 TRIMAGE COMPOSITES DART

Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
TRIMAGE COMPOSITES DART

Tailler le foam core afin d'ajuster le contour de la pièce à celui du moule.

31-01-07 DR

38.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.100 KILOGRAMME(s)/Unit Total : 0.100 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-5957-2

39.0 AAC0275 Catalyst N° DDM-9

Commentaire Qty.: 0.0032 PINTE(s)/Unit Total : 0.0032 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5921

40.0 FINITION 3 FINITION PIÈCE DART

Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART








Sceller le foam core qui a été exposé suite au taillage précédent selon I.G. # Sceller le Foam Core

Laisser sécher pendant minimum deux heures. 1-02-07 DR

Date: Vendredi, 2007-02-09 09:14:52

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY	
Numéro Job: 40970		Numéro Article: DKC134-0055	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
41.0	AAC0275	Catalyst N° DDM-9	
Commentaire Qty.: 0.0504 PINTE(s)/Unit Total : 0.0504 PINTE(s) Catalyst N° DDM-9 N° de Lot: <u>5921</u>			
42.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
Commentaire Qty.: 1.500 KILOGRAMME(s)/Unit Total : 1.500 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-5966-1</u>			
43.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MATÉRIEL Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350. Date: <u>2-02-07</u> Heure Début: _____ Heure Fin: _____ Sceau: <u>DR</u>			
44.0	INSPECTION 3	INSPECTION PIÈCE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs FAIRE LE LAMINAGE DES TISSUS Laminer deux pli de 9.7 oz 7781 S-Glass partout dans le moule. Le laminage doit être fait à l'aide de la résine N° 411-350 / 2% DDM-9. Date: <u>2-02-07</u> Heure Début: _____ Heure Fin: _____ Sceau: <u>DR CG SV</u>			
45.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE	
			
Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs EFFECTUER LA POCHE A VIDE Faire la poche à vide en appliquant les composantes dans l'ordre suivant: 1- Tissu à délaminer, 2- Film perforé P-3, 3- Feutre de drainage 4- Sac à vide Stretchlon 200 Laisser sécher pendant 4 heures minimum.			

Date: Vendredi, 2007-02-09 09:14:52

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40970Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0055

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Date: 2-02-07 Heure Début: _____ Heure Fin: _____ Sceau: DK CG SU

Curing Début: _____ Curing Fin: _____

46.0

DÉMOULAGE 1

DÉMOULAGE PIÈCE DART

Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
DÉMOULAGE DES PIÈCES

Démouler la pièce en se servant de la prise d'air sous le moule en faisant bien attention de ne pas abîmer les différentes surfaces de la pièce.

Date: 5-02-07 Heure Début: _____ Heure Fin: _____ Sceau: SU

47.0

TRIMAGE 3

TRIMAGE COMPOSITES DART

Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs
TRIMAGE DE FINITION

Perçer les 8 trous sur la section supérieure de la pièce ainsi que l'ouverture pour la porte à l'aide du gabarit N° DT5802.

Par l'intérieur, perçer les 8 dégagement de ø .745" pour les spacers N° D2213 (ne pas perçer la peau extérieure de la pièce)

Date: 5-02-07 Heure Début: _____ Heure Fin: _____ Sceau: SU

48.0

AAC0275

Catalyst N° DDM-9

Commentaire Qty.: 0.0048 PINTE(s)/Unit Total : 0.0048 PINTE(s)
Catalyst N° DDM-9N° de Lot: 5921

49.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.150 KILOGRAMME(s)/Unit Total : 0.150 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.N° de Lot: 1-5957-1

50.0

AAC0673

Fibre de verre Miapoxy 66

Commentaire Qty.: 0.0420 GALLON(s)/Unit Total : 0.0420 GALLON(s)
Fibre de verre Miapoxy 66N° de Lot: 1-5502-1

Date: Vendredi, 2007-02-09 09:14:52

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40970Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

51.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIELFaire la préparation de la résine selon les quantités requises, mix ratio 2% de Catalyst N° DDM-9 par
quantité de résine N° 411-350.Date: 6-02-07 Heure Début: _____ Heure Fin: _____ Sceau: DR SC

52.0 AAC0448 Spacer N° D2213

Commentaire Qty.: 8 UNITE(s)/Unit Total : 8 UNITE(s)

Spacer N° D2213 N° de Lot: 1-5949-1

53.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART

Commentaire Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs
ASSEMBLAGE GÉNÉRALE DES PIÈCESFaire l'assemblage des inserts (Spacer) N° D2213 dans les trous prévus à cet effet à l'aide de résine N°
411-350 chargé à l'aide de Fibre de verre courte Miapoxy 66.

Laminer un pièce de 9 oz. sur chacune des 2 zones de 4 spacers pour reboucher les trous

Appliquer une pression sur les pièces de 9 oz à l'aide d'un bloc de bois et de pinces autobloquantes

Laisser sécher pendant 4 heures minimum.

Date: 6-02-07 Heure Début: _____ Heure Fin: _____ Sceau: DR SC

Curing Début: _____ Curing Fin: _____

54.0 AAC0275 Catalyst N° DDM-9

Commentaire Qty.: 0.0096 PINTE(s)/Unit Total : 0.0096 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 5921

55.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-5957-2

Date: Vendredi, 2007-02-09 09:14:52

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40970

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

56.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 5-02-07 Heure Début: _____ Heure Fin: _____ Sceau: SU HCG

57.0 LAMINAGE. LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 55.0000Min Total Run : 0.9167Hrs
FAIRE LE LAMINAGE DES TISSUS

Retirer les pinces et blocs de bois

Faire le laminage d'un pli de 9.7 oz 7781 S-Glass sur le contour de la pièces. Selon le dessin.

Laisser sécher pendant 4 heures minimum.

Date: 5-02-07 Heure Début: _____ Heure Fin: _____ Sceau: SU HCG

Curing Début: _____ Curing Fin: _____

58.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

Repercer les 8 trous des spacers afin de les déboucher

Sabler les surfaces de la pièces pour aider à l'adhésion du primer et enlever les imperfections.

59.0 AAC0671 Dupont Primer N° 1104S

Commentair Qty.: 0.5000 GALLON(s)/Unit Total : 0.5000 GALLON(s)
Dupont Primer N° 1104S

N° de Lot: 1-5931-2

60.0 AAC0670 Dupont Activation N° 7975S

Commentair Qty.: 1.0000 PINTE(s)/Unit Total : 1.0000 PINTE(s)
Dupont Activation N° 7975S

N° de Lot: 1-5931-1

Date: • Vendredi, 2007-02-09 09:14:52

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 40970

Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

61.0 AAC0672 Dupont Reducer N° 12375S

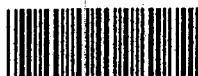
Commentair Qty.: 0.1250 GALLON(s)/Unit Total: 0.1250 GALLON(s)

Dupont Reducer N° 12375S

N° de Lot:

1-5931-3

62.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run: 0.0000Hrs

PRÉPARATION DU MATÉRIEL DART

7-02-07 YL
29-01

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant.

63.0 PEINT/ PRIMER2 PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

PEINTURE / PRIMER DART

Appliquer une couche de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) selon I.G. #

Application du primer

Laisser sécher pendant 3 heures minimum

7-02-07 YL

Date: _____ Heure Début: _____ Heure Fin: _____ Sceau: _____

64.0 AAC0451 Label N° D0600-142

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

Label N° D0600-142 N° de Lot: _____

65.0 AAC0444 Surface Veil

Commentair Qty.: 1.00 VERGE CAR(s)/Unit Total: 1.00 VERGE CAR(s)

Surface Veil N° de Lot: _____

66.0 AAC0501 Résine Mia-Poxy

Commentair Qty.: 0.015 GALLON(s)/Unit Total: 0.015 GALLON(s)

Résine Mia-Poxy N° de Lot: _____

67.0 AAC0502 Durcisseur 95 Pour Résine Mia-Poxy

Commentair Qty.: 0.030 PINTE(s)/Unit Total: 0.030 PINTE(s)

Durcisseur 95 Pour Résine Mia-Poxy N° de Lot: _____

68.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs

ASSEMBLAGE GÉNÉRALE DART

Coller le label D0600-142 sur le spacepod en plaçant un surface veil eu dessous et par dessus le label à l'aide de résine Mia Poxxy. Selon I.F. # DKC134-0019-13

Date: • Vendredi, 2007-02-09 09:14:52

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40970

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

Date: _____ Heure début: _____ Heure fin: _____ Sceau: _____

69.0

AAC0058

Polysoft 1.3 kg # 003012 Sikkens

Commentair Qty.: 0.020 UNITE(s)/Unit Total : 0.020 UNITE(s)
Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-5957-1

70.0

AAC0059

Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.078 UNITE(s)/Unit Total : 0.078 UNITE(s)
Durcisseur Polysoft #004009 Sikkens

71.0

FINITION 3

FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs
FINITION GÉNÉRALE

8-02-07 HA

Faire les réparations de finition s'il y a lieu à l'aide du Sikkens

Faire un léger sablage (Grit 220) de toute les surfaces.

Date: _____ Heure Début: _____ Heure Fin: _____ Sceau: _____

72.0

AAC0671

Dupont Primer N° 1104S

Commentair Qty.: 0.2500 GALLON(s)/Unit Total : 0.2500 GALLON(s)
Dupont Primer N° 1104S N° de Lot: 1-5934-2

73.0

AAC0670

Dupont Activator N° 7975S

Commentair Qty.: 0.5000 PINTE(s)/Unit Total : 0.5000 PINTE(s)
Dupont Activator N° 7975S N° de Lot: 1-5931-1

74.0

AAC0672

Dupont Reducer N° 12375S

Commentair Qty.: 0.0625 GALLON(s)/Unit Total : 0.0625 GALLON(s)
Dupont Reducer N° 12375S N° de Lot: 1-5931-3

75.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
PRÉPARATION DU MATÉRIEL

Masquer le label.

8-02-07 YL

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40970

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description:

76.0 PEINT/PRIMER2 PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs
APPLICATION DE PRIMER

Appliquer deux couche de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) selon les instruction du manufacturier, en prenant bien soin d'attendre 10 minutes entre les couches.

Laisser sécher pendant 3 heures minimum

Date: 8-02-07 Heure Début: _____ Heure Fin: _____ Sceau: YL

77.0 INSPECTION 3 INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
INSPECTION GÉNÉRALE

Faire l'inspection générale de la pièces selon le dessin par le département de la qualité.

Date: 9-02-07 Sceau:  Initiales: 

78.0 EMBALLAGE 3 EMBALLAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
EMBALLAGE PIÈCE DART

Faire l'emballage dans le contenant approprié.

Quantité: _____ Date: _____ Sceau: _____

Quantité: _____ Date: _____ Sceau: _____

EMBALLAGE : QTY: 1 9/2/07



Date: Wednesday, 12/20/2006 1:45:53 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACEPOD DOOR RH
Job Number : 30038	
Estimate Number : 12599	
P.O. Number :	Part Number : D31862M
This Issue : 12/20/2006 S.O. No. :	Drawing Number : D3186 REV. <i>BC LE 07.01.18</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : PURCHASED PARTS	Drawing Revision : <i>BC LE 07.01.18</i>
Previous Run : 30037	Material :
Written By :	Due Date : 2/5/2007 Qty: 1 Um: Each
Checked & Approved By : <i>JA 061220</i>	
Comment : Est Rev: A New Issue 06-12-04 ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	PG	PURCHASING
-----	----	------------

**Comment:** PURCHASINGIssue P/O: *2767*

Description: D3186-2M Door

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 3 Items from Previous steps

*C Load 121 21**①*

2.0	D31862P	Spacepod Door
-----	---------	---------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Spacepod Door

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

0504/02/280

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------

**Comment:** DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3186. Visual inspection. Check for void spot and pins.

070305 (Fitted)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: *MWA**0713/05*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 17 Date: 07/04/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Wednesday, 12/20/2006 1:45:54 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR RH

Job Number: 30038

Part Number: D31862M

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE



07/04/05

Job Completion



U ST-04-05

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

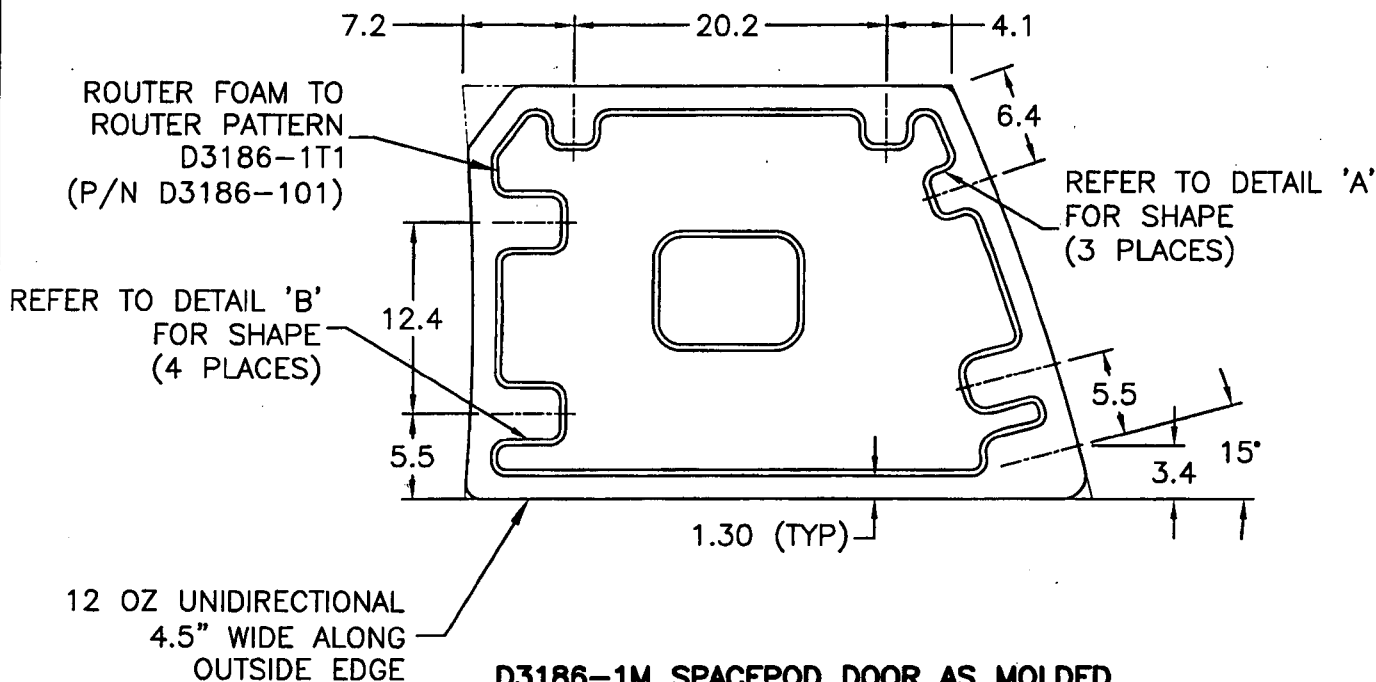
NOTE: Date & initial all entries

DART

DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED H	DRAWING NO. D3186	REV. C SHEET 1 OF 5
DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

**D3186-1M SPACEPOD DOOR AS MOLDED****RELEASED**
06.12.22**NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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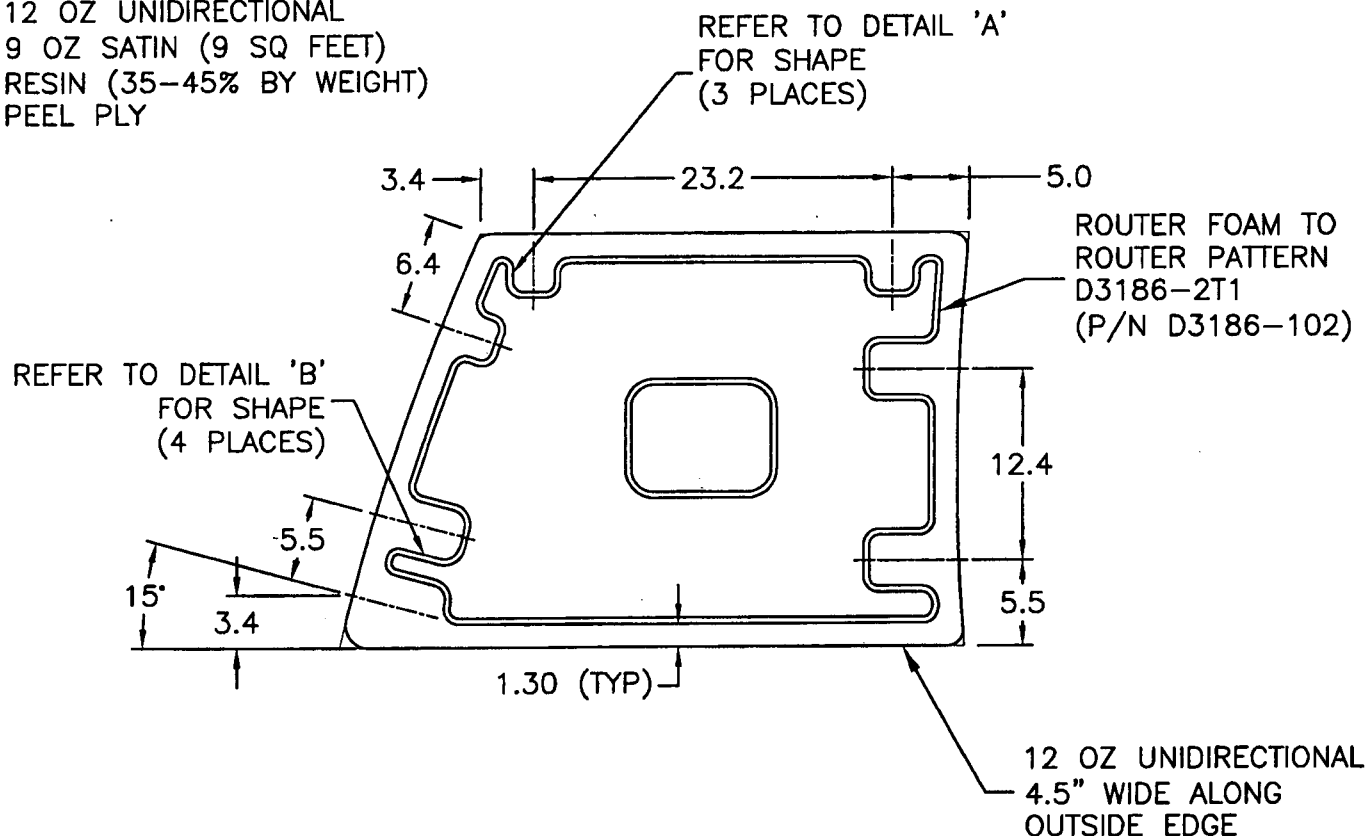
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CHECKED PH	APPROVED H	DRAWING NO. D3186	REV. C SHEET 2 OF 5
DATE 06.12.13		TITLE SPACEPOD DOOR	SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED
06.12.13**D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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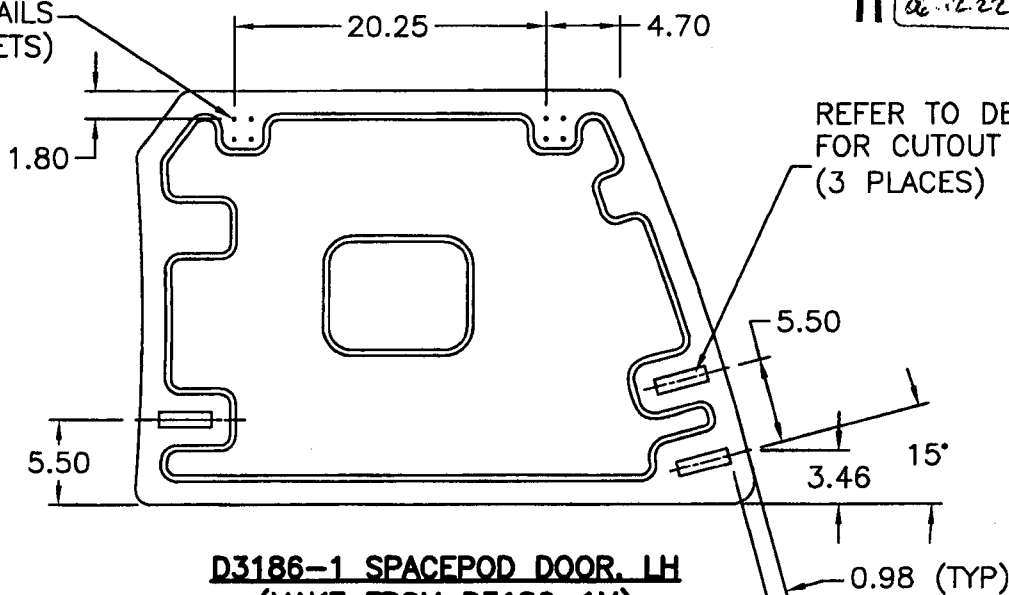
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DATE 06.12.13		TITLE SPACEPOD DOOR	SCALE NTS

RELEASED
ai-1222

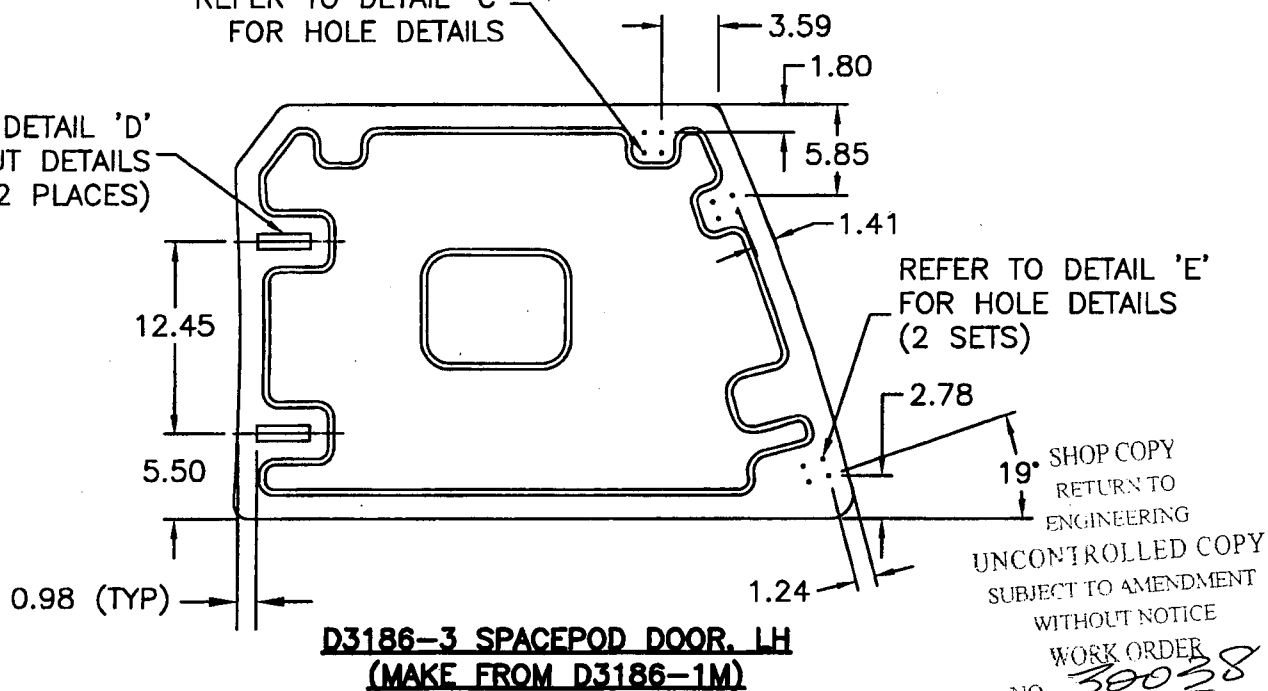
REFER TO DETAIL 'C'
FOR HOLE DETAILS
(2 SETS)



D3186-1 SPACEPOD DOOR, LH
(MAKE FROM D3186-1M)

REFER TO DETAIL 'C'
FOR HOLE DETAILS

REFER TO DETAIL 'D'
FOR CUTOUT DETAILS
(2 PLACES)



D3186-3 SPACEPOD DOOR, LH
(MAKE FROM D3186-1M)

NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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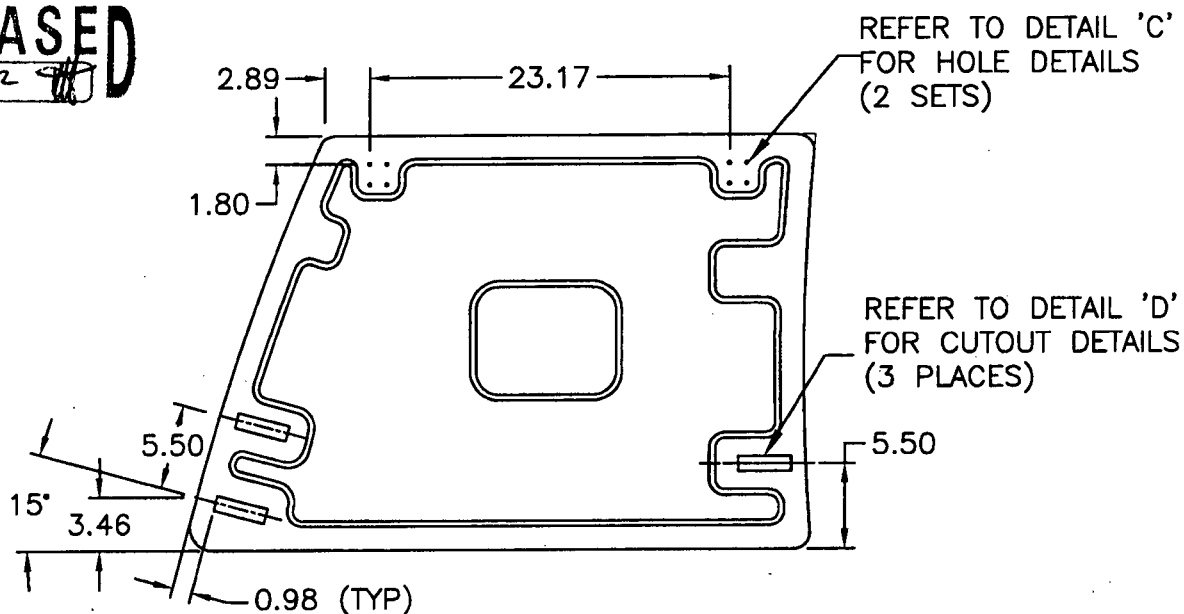
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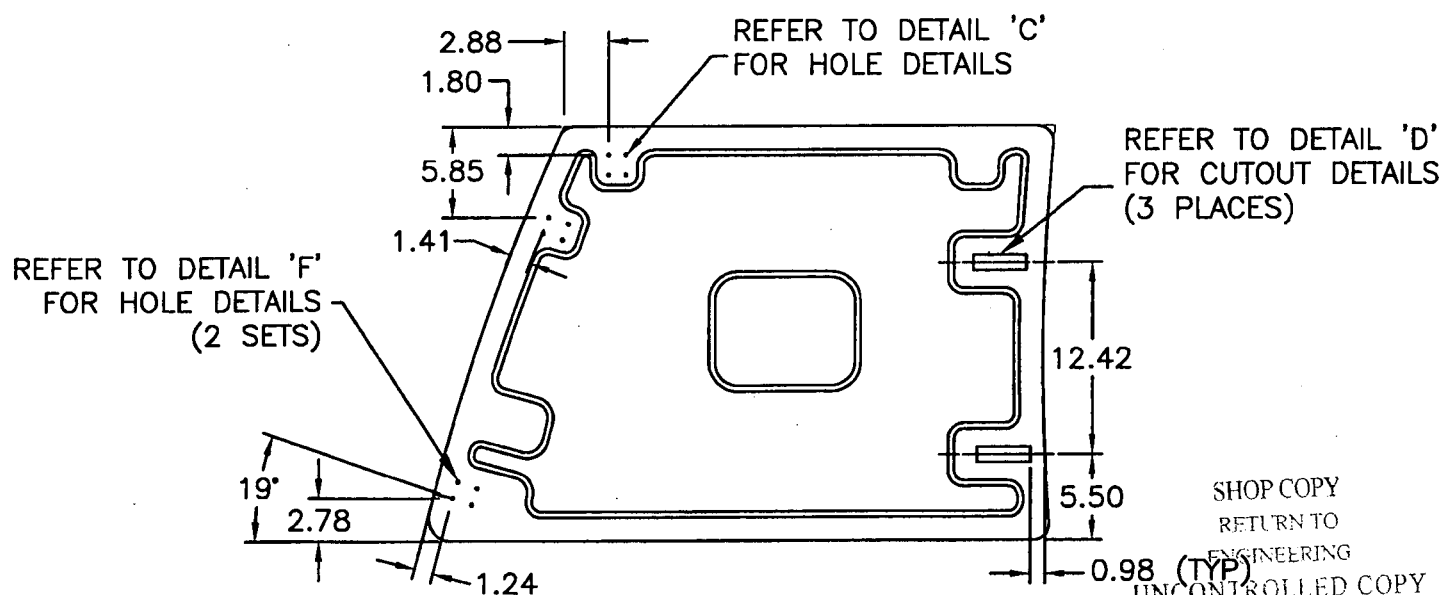


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DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS

RELEASED
06.12.22



D3186-2 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)

NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

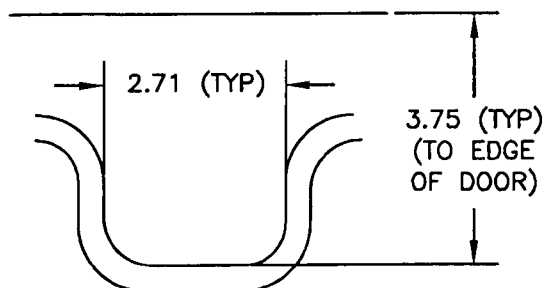
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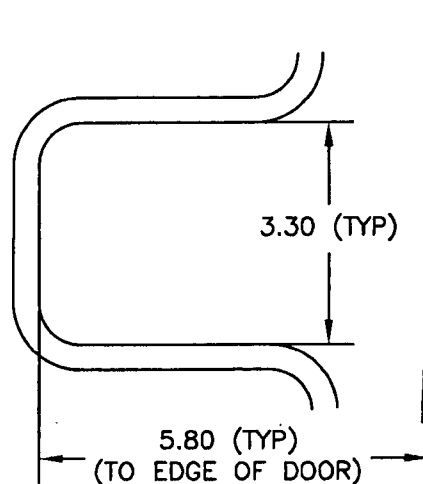
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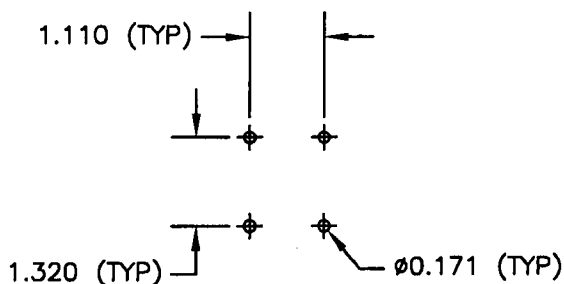
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DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS



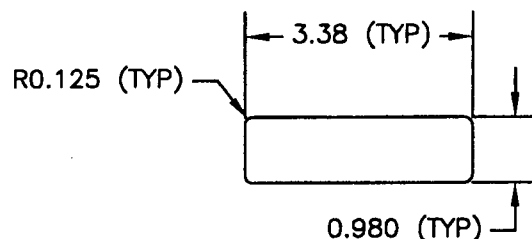
DETAIL A



DETAIL B

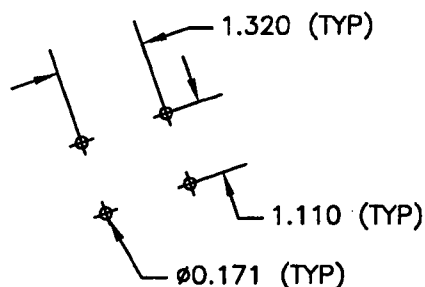


DETAIL C

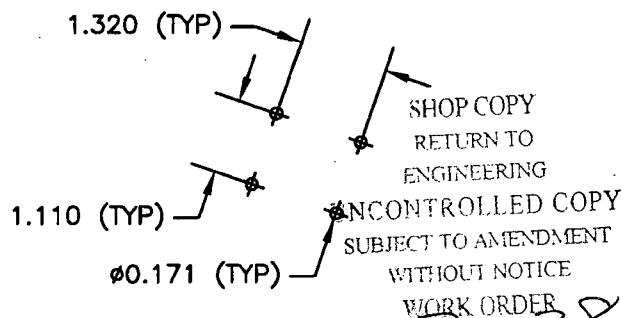


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D



DETAIL E



DETAIL F

NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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RELEASED
06.12.22



DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	11642
Customer #	DART

Telephone: (819) 533-5788
Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by	Your PO #		GST/PST #	
27/02/07	21/12/06	5092	C. Lavoie	PQ00002767			
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0052	D3186-1M Spacepod Door LH B30018 Dwg. Rév.: C Job: 41038 U de M : Each			
1	0	1	DKC134-0054	D3186-2M Spacepod Door RH B30038 Dwg. Rév.: C Job: 41039 U de M : Each			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

27-2-07

Quality department

AQ-357

as per inspection report

Description du produit: Spacepod door			Vendor code:	
Client: Dart Aerospace	P/N: D3188-2M	Rev.: F/D : C	EO: n/a	
		Rev. P/L : n/a		
No commande:	Livraison:	Physical change:		
	FAI <input type="checkbox"/>	FI <input checked="" type="checkbox"/>		
Formulaire d'inspection: INDK-134-0054		Par: Paul Aubry		
Numéro de travail: 41039		Date : 27-02-2007		
		estampe		
Quantité à produire : 1		Qtée finale acceptée: 1		


Spécification		S	A	R	Méthode d'inspection	Notes
Resin Derakane 411B1620 / 411B7530					C. of C. # 1-5988-1	
Fibre 9 oz no.7781 satin, 12 oz unidirectional fiberglass					C. of C. # Refer to planning	
Foam A500 core cell					C. of C. # 3-5915-3	
Grey highbuilt dupont primer 1144-s					C. of C. # 1-5931-2	

Référence à dessin		Dimension et tolérance (pouce)	Dimension inspectée	S	A	R	Méthode d'inspection	Notes
	3.4 ± 0.1	4.15				✓	Caliper	
	23.2 ± 0.1	23.2			✓		tape	
	5.0 ± 0.1	4.67				✓	Caliper	
	12.4 ± 0.1	12.2				✓	Caliper	
	5.5 ± 0.1	5.63				✓	Caliper	
	12 oz unidirectionnal 4.5 ± 0.1 wide along outside edge	5.0 @ 5.1				✓	Caliper	
	1.30 (typ) ± 0.03	0.92 @ 1.02				✓	Caliper	
	3.4 ± 0.1	3.43			✓		Caliper	

	15 deg \pm 0.5	15°		✓	angle	
	5.5 \pm 0.1	5.5		✓	Caliper	
	6.4 \pm 0.1	6.1		✓	Caliper	
Detail A	2.71 (Typ) \pm 0.03	2.3 @ 2.65		✓	Caliper	
	3.75 (typ) \pm 0.03	3.65 @ 3.8		✓	Caliper	
Detail B	3.30 (typ) \pm 0.03	3.2		✓	Caliper	
	5.80 (typ) \pm 0.03	5.2 @ 5.5		✓	Caliper	

Inspection visuelle

Référence à	Opération	S	A	R	Méthode d'inspection	Notes
	Aspect visuel de la pièce, la surface apparente devrait contenir aucun défaut		✓		Visuel	
	Tap test (délamination)		✓			

Acceptation final par: 		Date: 27-02-2007
<input type="checkbox"/> Refusé	<input checked="" type="checkbox"/> Qtée acceptée: 1	R.M.N.C. No.:
Commentaires: Rapport d'inspection pour la mise à jour du dessin par le client.		

Date: Mercredi, 2007-02-21 13:42:13
Jilisateur: Marc Dubé

Feuille de Procédé

Client	: DART	Dart Aerospace Ltd.	Nom Dessin	: SPACEPOD DOOR
Numéro Job	: 41039		Numéro Article	: DKC134-0054
Numéro Soumission	: 2586		Numéro Dessin	: D3186
Numéro B.A.	:		Projet Numéro	: DKC134
Cette fois	: 2007-02-21	No. B.V. :	Révision dessin	: B C @
Prsht Rev.	: NC		Matériel	: Fibre 7781 et Résine 411-350
Prem. fois	: - -	Type :	Date Dûe	: 2007-02-28
Job précédente	: 40886		Qté:	1 Udm: UNITE

Écrit par : _____

Vérifié & Approuvé par : _____

Commentaires : N° de pièce Dart Aerospace : D31862M
N° de Projet Delastek: DK-362

Process Sheet Rev.: 00 Création du premier à partir du DKC134-0018

Produit additionnel

Numéro Job:



Séq.: Machine ou Opération: Description :

1.0 AC0303 Frekote 44NC

Commentair Qty.: 0.020 GALLON(s)/Unit Total : 0.020 GALLON(s)
Frekote 44NC

2.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MOULE

Faire la préparation du moule N° DT 8005 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006

Date: 9/6/2007 Heure Début: _____ Heure Fin: _____ Sceau: _____



3.0 AC0409 Tissu à délaminer Release ply B

Commentair Qty.: 3.28 VERGE(s)/Unit Total : 3.28 VERGE(s)
Tissu à délaminer Release ply B

4.0 AC0407 Wrightlon 5200 Bleu P3

Commentair Qty.: 3.59 VERGE(s)/Unit Total : 3.59 VERGE(s)
Wrightlon 5200 Bleu P3

5.0 AC0408 Feutre de drainage N° Airweave N 10

Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)
Feutre de drainage N° Airweave N 10

6.0 AC0752 Stretchlon 200 poche à vide Vert

Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)
Stretchlon 200 poche à vide Vert

Date: Mercredi, 2007-02-21 13:42:13
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41039

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0054

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
7.0	AAC0326	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentair Qty.: 4.5 VERGE(s)/Unit Total : 4.5 VERGE(s)
9.7 oz 7781 Weave "S" glass #FG-778150-125Y N° de Lot: 1-5905-1

8.0	AAC0443	Fiberglass 12 oz Unidirectional
-----	---------	---------------------------------

Commentair Qty.: 1.00 VERGE CAR(s)/Unit Total : 1.00 VERGE CAR(s)
Fiberglass 12 oz Unidirectional N° de Lot: 5955

9.0	AC0098	Ruban à gommer jaune #: T/AT-200Y
-----	--------	-----------------------------------

Commentair Qty.: 2.2500 RL(s)/Unit Total : 2.2500 RL(s)
Ruban à gommer jaune #: T/AT-200Y

10.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
------	---------------	------------------------------



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe:

Appliquer le Ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 9/02/07 Heure Début: _____ Heure Fin: _____ Sceau:

11.0	AAC0275	Catalyst N° DDM-9
------	---------	-------------------

Commentair Qty.: 0.0640 PINTE(s)/Unit Total : 0.0640 PINTE(s)
Catalyst N° DDM-9 N° de Lot: 5921

12.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.
------	---------	---

Commentair Qty.: 0.500 KILOGRAMME(s)/Unit Total : 0.500 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min N° de Lot: 1-5988-1

13.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
------	---------------	------------------------------



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 12/02/07 Heure Début: _____ Heure Fin: _____ Sceau:

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41039

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0054

Numéro Job:



Séq.: Machine ou Opération: Description :

14.0 LAMINAGE. LAMINAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
FAIRE LE LAMINAGE DES TISSUS

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8004 et ensuite imbiber un pli de tissu 9.7oz.

Recommencer l'opération pour le deuxième pli.

Date: 12/02/07 Heure Début: _____ Heure Fin: _____ Sceau: _____



15.0 POCHÉ À VIDE 1 FAIRE LA POCHÉ À VIDE



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
EFFECTUER LA POCHÉ A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 12/02/07 Heure Début: _____ Heure Fin: _____ Sceau: _____



Curing Début: _____ Curing Fin: _____

16.0 AAC0275 Catalyst N° DDM-9

Commentaire Qty.: 0.0120 PINTÉ(s)/Unit Total : 0.0120 PINTÉ(s)
Catalyst N° DDM-9

N° de Lot: 5921

17.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-5988-1

Date: Mercredi, 2007-02-21 13:42:13
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41039

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0054

Numéro Job:



Séq.: Machine ou Opération: Description :

18.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantités requises, mix ratio 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350 Imbiber toutes les surfaces du foam core.

Laisse sécher pendant 2 heures.

Date: 21/02/07

Heure Début: 13:42

Heure Fin: 15:42

Sceau:



19.0 AAC0452 Polybond B46F

Commentaire Qty.: 0.082 KIT(s)/Unit Total : 0.082 KIT(s)
Polybond B46F N° de Lot: 1-5865-1

20.0 DKC134-0057 Foam Core N° D3186-102 (Porte D3186-2)

Commentaire Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
Foam Core N° D3186-102 (Porte D3186-2)

No LOT 3-5915-3

21.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
ASSEMBLAGE GÉNÉRALE DES PIÈCES

Retirez le bagging.

Pour aider au positionnement du 12 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz.. Retirer le gabarit de trimage.

Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer son contour sur le 9 oz. (Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz.)

FIRST OFF 21-2-07



Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0024 et positionner le foam Core sur le moule selon le dessin, et selon les lignes de positionnement prévues à cet effet.

Date: 21/02/07

Heure Début: 15:42

Heure Fin: 17:42

Sceau:



22.0 POCHÉ À VIDE 1 FAIRE LA POCHÉ À VIDE



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
EFFECTUER LA POCHÉ À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer
- 2- Feutre de drainage

Date: Mercredi, 2007-02-21 13:42:13
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41039

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0054

Numéro Job:



Séq.: Machine ou Opération: Description :

3- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum.

Retirez le bagging avant la fin de la polymérisation (entre 1 heure et 1 heure 1/2) afin d'enlever le surplus de polybond

Date: 21/02/07 Heure Début: _____ Heure Fin: _____ Sceau: _____



Curing Début: _____ Curing Fin: _____

23.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0400 PINTE(s)/Unit Total : 0.0400 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5921

24.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.000 KILOGRAMME(s)/Unit Total : 1.000 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-5988-1

25.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 22/02/07 Heure Début: _____ Heure Fin: _____ Sceau: _____



26.0 LAMINAGE. LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
FAIRE LE LAMINAGE DES TISSUS

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du pli de tissu de 12 oz tout le tour de la porte.

Faire le laminage du dernier pli de 9.7 oz.

Date: 22/02/07 Heure Début: _____ Heure Fin: _____ Sceau: _____



Date: Mercredi, 2007-02-21 13:42:13
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41039

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0054

Numéro Job:



Séq.: Machine ou Opération: Description :

27.0 POCHE À VIDE 1 FAIRE LA POCHE À VIDE



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 22/02/07 Heure Début: _____ Heure Fin: _____ Sceau: _____



Curing Début: _____ Curing Fin: _____

28.0 DÉMOULAGE 1 DÉMOULAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
DÉMOULAGE DES PIÈCES

Démouler la pièce en faisant bien attention de ne pas abimer les coins et le " edges ".

Sabler la surface de la pièce qui était en contact avec le moule afin d'éliminer le fini lisse de celui-ci.

Date: 23/02/07 Heure Début: _____ Heure Fin: _____ Sceau: _____



29.0 TRIMAGE 3 TRIMAGE COMPOSITES DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
TRIMAGE DE FINITION

Trimer la pièce l'aide du gabarit de trimage prévu à cet effet.

Perçer les " Latch " et les trous de pentures selon le dessin N° D3186

Date: 23/02/07 Heure Début: _____ Heure Fin: _____ Sceau: _____



Date: Mercredi, 2007-02-21 13:42:13
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41039

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0054

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

30.0	AAC0671	Dupont Primer N° 1104S
------	---------	------------------------

Commentair Qty.: 0.1390 GALLON(s)/Unit Total : 0.1390 GALLON(s)
Dupont Primer N° 1104S

N° de Lot: 1-5931-2

31.0	AAC0670	Dupont Activator N° 7975S
------	---------	---------------------------

Commentair Qty.: 0.2800 PINTE(s)/Unit Total : 0.2800 PINTE(s)
Dupont Activator N° 7975S

N° de Lot: 1-5931-1

32.0	AAC0672	Dupont Reducer N° 12375S
------	---------	--------------------------

Commentair Qty.: 0.0350 GALLON(s)/Unit Total : 0.0350 GALLON(s)
Dupont Reducer N° 12375S

N° de Lot: 1-5692-2

33.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
------	---------------	------------------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
PRÉPARATION DU MATÉRIEL DART

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

34.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
------	---------------	------------------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
PRÉPARATION DU MATÉRIEL DART

Appliquer une première couche de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) Selon I.G.
Application primer

Laisser sécher pendant 3 heures.

23.02.07

Date: _____ Heure Début: _____ Heure Fin: _____ Sceau:

35.0	FINITION 3	FINITION PIÈCE DART
------	------------	---------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

Faire le sablage de la pièce à l'aide de papier sablé grit 220 afin de corriger les imperfection et enlever le lustre du primer.

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41039

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0054

Numéro Job:



Séq.: Machine ou Opération: Description :

36.0 AAC0451 Label N° D0600-142

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)
Label N° D0600-142 N° de Lot: *a enlever*

37.0 AAC0444 Surface Veil

Commentair Qty.: 0.08 VERGE(s)/Unit Total: 0.08 VERGE(s)
Surface Veil N° de Lot:

38.0 AAC0501 Résine Mia-Poxy

Commentair Qty.: 0.015 GALLON(s)/Unit Total: 0.015 GALLON(s)
Résine Mia-Poxy N° de Lot: *N/A*

39.0 AAC0502 Durcisseur 95 Pour Résine Mia-Poxy

Commentair Qty.: 0.030 PINTÉ(s)/Unit Total: 0.030 PINTÉ(s)
Durcisseur 95 Pour Résine Mia-Poxy N° de Lot: *N/A*

40.0 FAB GÉNÉRALE 3 FABRICATION GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Hrs Total Run: 15.0000Hrs
FABRICATION GÉNÉRALE DART

Coller le Label N° 0600-142 selon les séquences suivantes:

- 1 Surface Veil
- 2- Label
- 3- Surface Veil

a enlever

À l'aide de la résine Mia-Poxy selon le dessin D3186.

Laisser sécher pendant 6 heures.

Date: _____ Heure Début: _____ Heure Fin: _____ Sceau: _____

41.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentair Qty.: 0.050 UNITE(s)/Unit Total: 0.050 UNITE(s)
Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: *1-6005-1*

42.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.039 UNITE(s)/Unit Total: 0.039 UNITE(s)
Durcisseur Polysoft #004009 Sikkens *1-6005-1*

43.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run: 0.1667Hrs
FINITION GÉNÉRALE

Faire les réparations de finition s'il y a lieu, à l'aide de Sikkens.

Date: Mercredi, 2007-02-21 13:42:13
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41039

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0054

Numéro Job:



Séq.: Machine ou Opération: Description:
Date: 26/02/07 Heure Début: _____ Heure Fin: _____ Sceau: 61

44.0 AAC0671 Dupont Primer N° 1104S

Commentair Qty.: 0.1390 GALLON(s)/Unit Total: 0.1390 GALLON(s)
Dupont Primer N° 1104S N° de Lot: 1-5931-2

45.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 0.2800 PINTE(s)/Unit Total: 0.2800 PINTE(s)
Dupont Activator N° 7975S N° de Lot: 1-5931-1

46.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.0350 GALLON(s)/Unit Total: 0.0350 GALLON(s)
Dupont Reducer N° 12375S N° de Lot: 1-5932-2

47.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs
PRÉPARATION DU MATÉRIEL

FEB 26 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant.

48.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run: 0.3333Hrs
APPLICATION DE PRIMER

Masquer le label.

Appliquer une deuxième couche de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) Selon I.G.

Application de primer.

FEB 26 2007

Date: _____ Heure Début: _____ Heure Fin: _____ Sceau: 16



49.0 INSPECTION 3 INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs
INSPECTION PIÈCE DART



27-02-2007

Voir Rapport d'inspection
de l'usine client

Emballage AT 1

27/2/07



Date:
User:Wednesday, 12/20/2006 1:46:37 PM
Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SPACEPOD BODY RH
Job Number :	30048		
Estimate Number :	12596		
P.O. Number :		Part Number :	D31882M
This Issue :	12/20/2006	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3188 REV. <i>PC</i>
First Issue :	11	Project Number :	N/A
Previous Run :	30047	Drawing Revision :	<i>PC</i>
	Type :	Material :	
	PURCHASED PARTS	Due Date :	2/5/2007
Written By :	<i>[Signature]</i>	Qty:	1
Checked & Approved By :	<i>[Signature]</i>	Um:	Each
Comment :	Est Rev:A New issue ecn882 06-11-30 EC		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D2213

Aluminum Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Ship To Delastek

8

D2213

Spacer

Batch: *B25325**C2071071028*

2.0

PG

PURCHASING

**Comment:** PURCHASINGIssue P/O: *2762*

Description: D3188-2M BODY

SHIP: D2213 Spacers

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 2 Items from Previous steps

3.0

D31882P

Spacepod Body



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Spacepod Body

4.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from
Delastek is attached.

C2071071028

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Q Date: 07/04/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/20/2006 1:46:37 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY RH

Job Number: 30048

Part Number: D31882M

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188 .Visual inspection. Check for void spot and pins.

ml 07/03/12

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ml 07/03/12

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①
R 07/04/05

Job Completion



A 07-04-05

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN		DRAWN BY		DART AEROSPACE LTD	
JB		LE		HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	APPROVED	PH	DRAWING NO.	REV. C
DATE	06.12.13			D3188	SHEET 1 OF 11
				SPACEPOD BODY	SCALE
					NTS
A		03.04.03		NEW ISSUE	
B		06.10.06		UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	
C		06.12.13		REMOVED D0600-XXX LABELS	

GENERAL NOTES:

1. REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
2. LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
3. MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

4. MOLD SHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

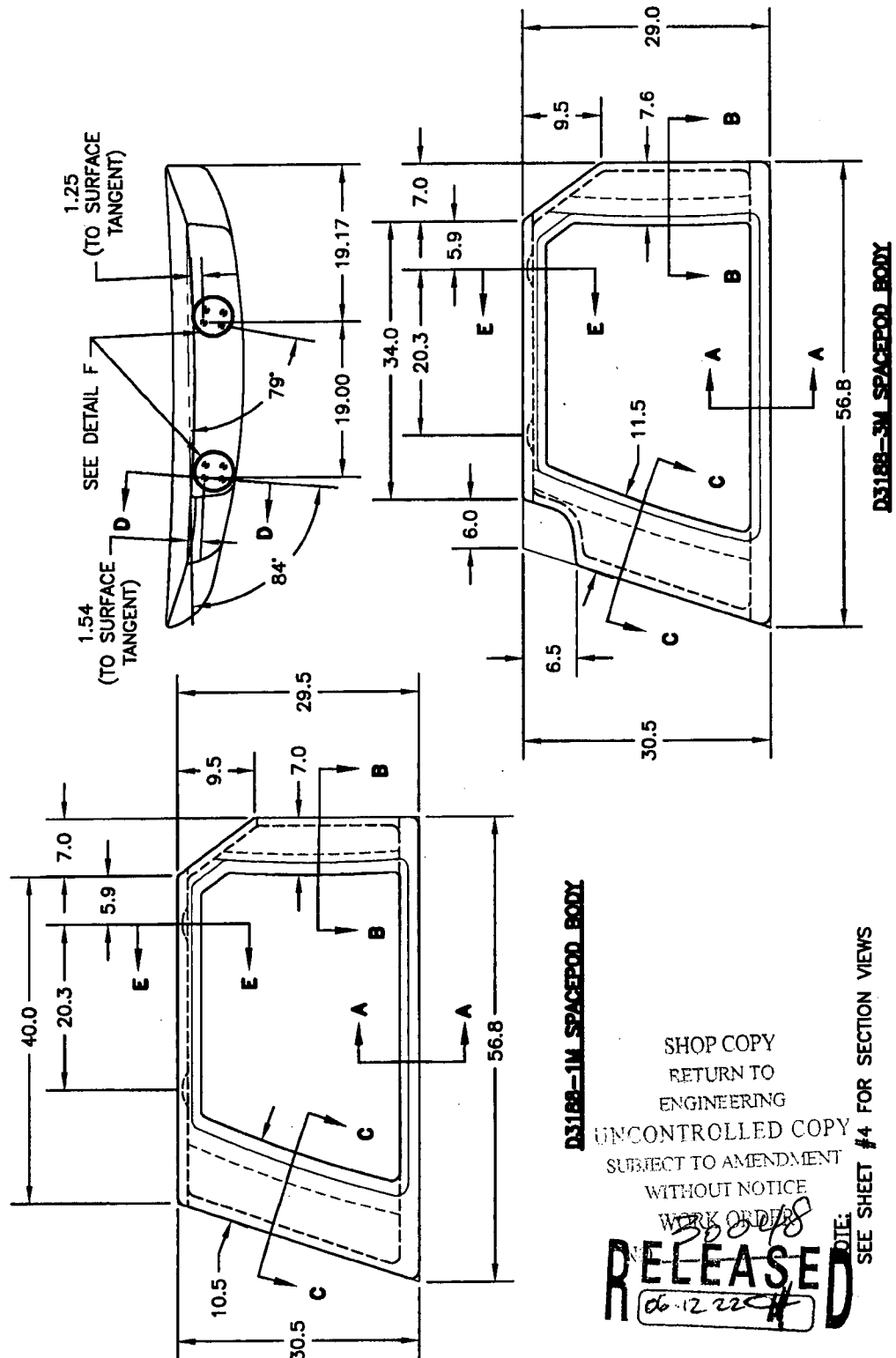
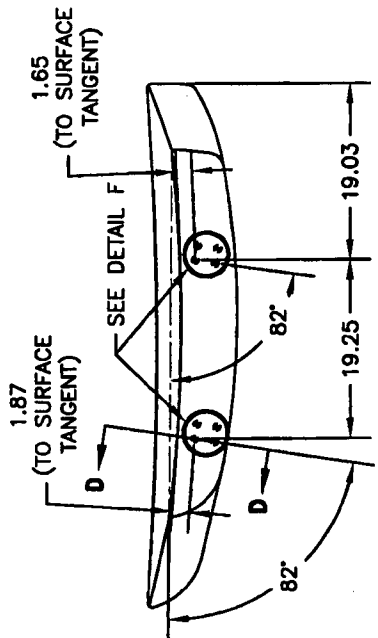
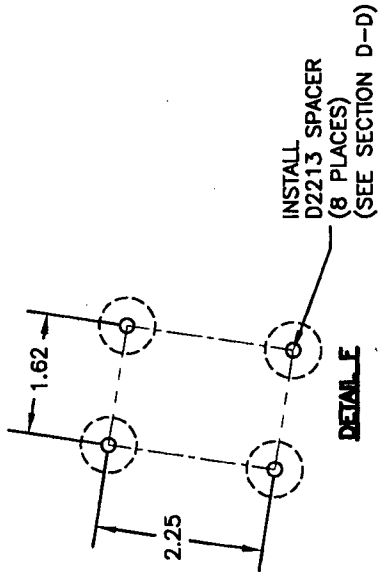
5. APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
6. FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S
7. ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 20078
RELEASED
06.12.22



DESIGN JB	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3188	REV. C SHEET 2 OF 11
DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS



D3188-1M SPACEPOD BODY

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WORK ORDER

RELEASED
30048
06-12-22

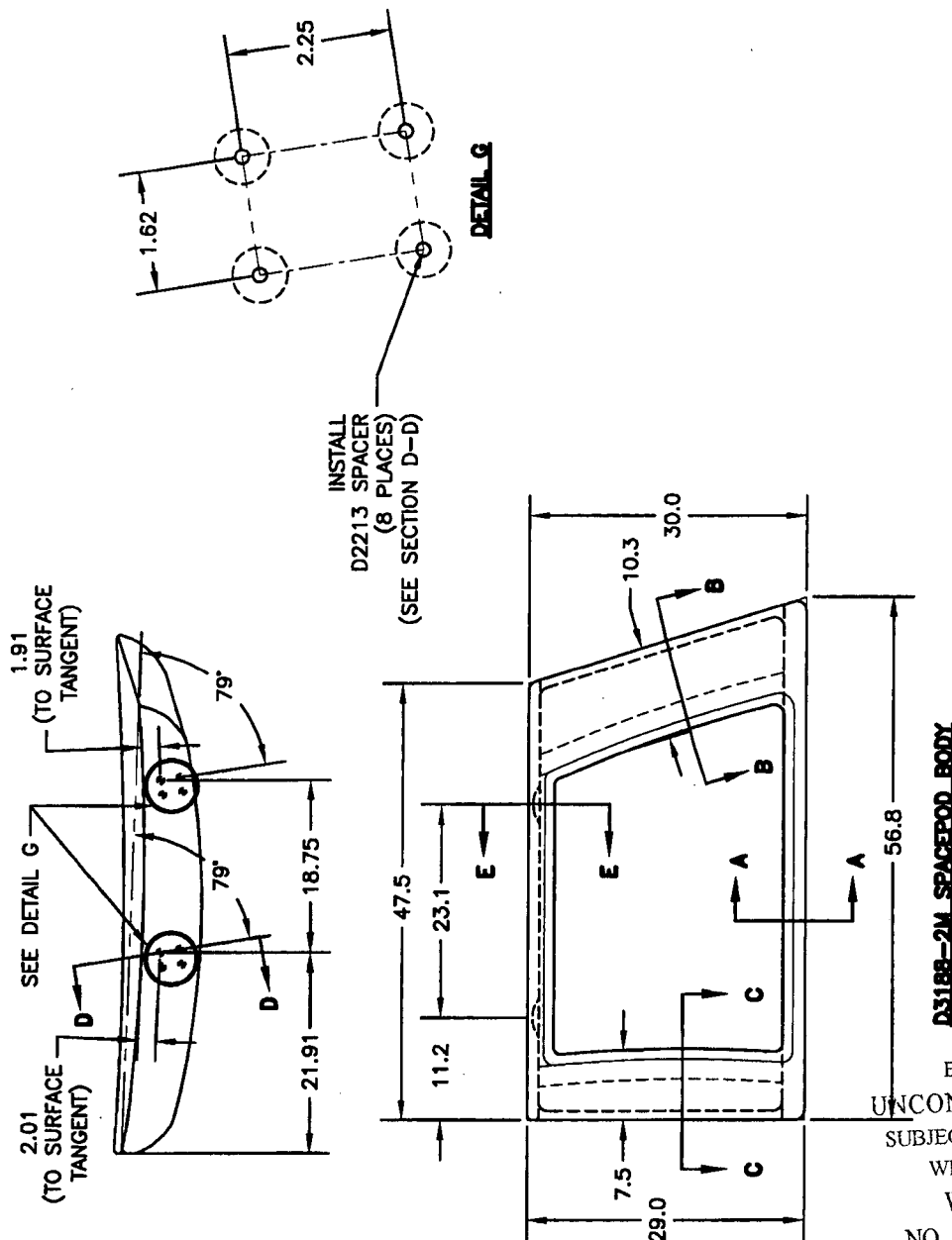
NOTE:
SEE SHEET #4 FOR SECTION VIEWS

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DESIGN JB	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3188	REV. C SHEET 3 OF 11
DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **30048**

RELEASED
06.12.22

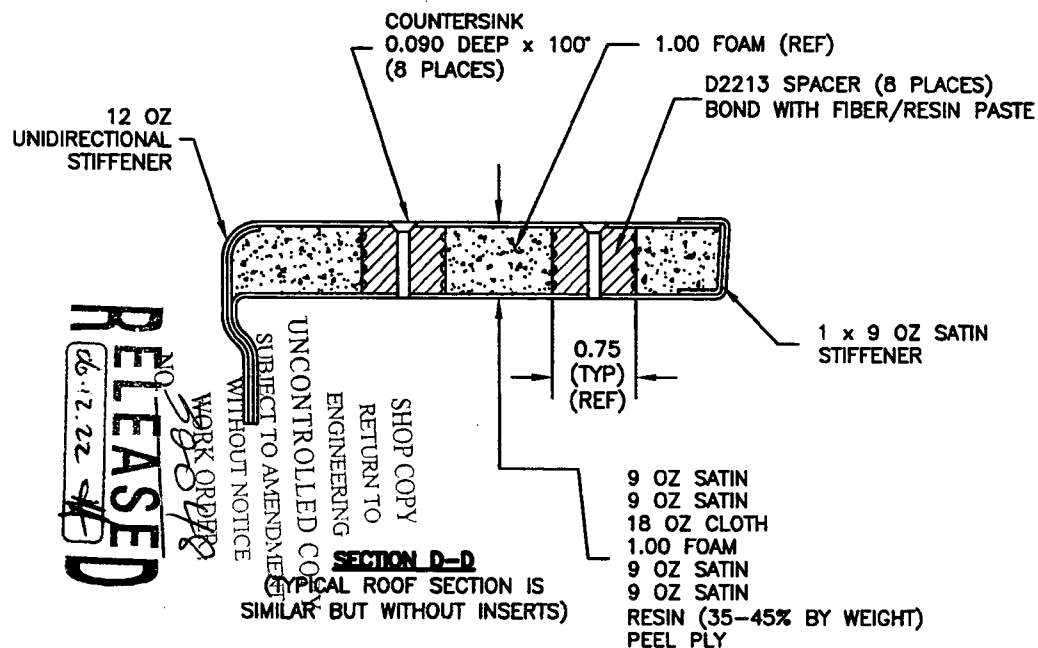
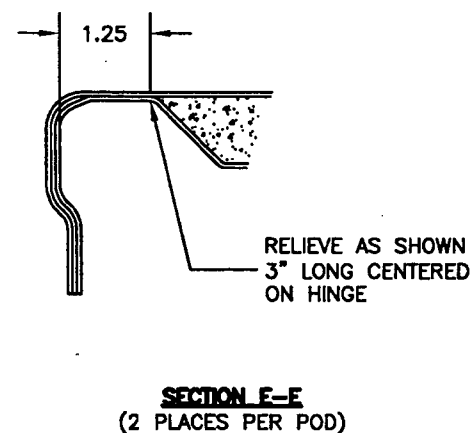
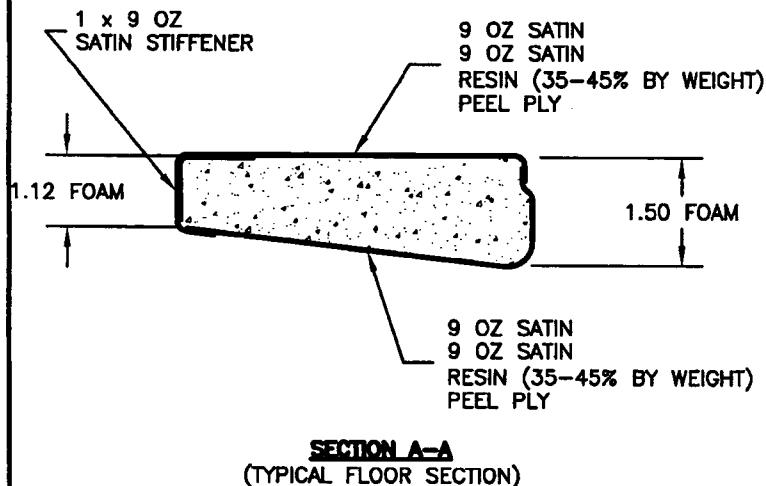
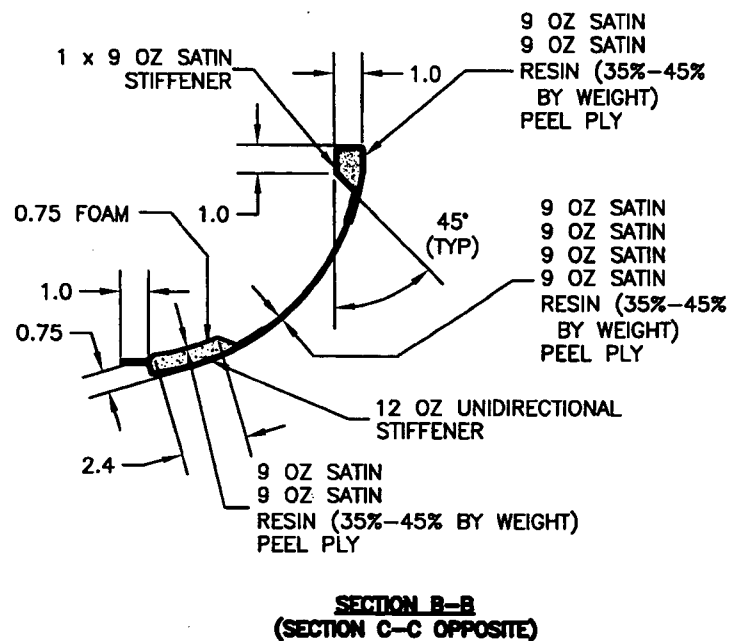
NOTE:
SEE SHEET #4 FOR SECTION VIEWS

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CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA	
DATE	06.12.13	TITLE	D3188	SPACEPOD BODY	SHEET 4 OF 11
					SCALE
					NIS



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NO 06.12.22
WORK ORPH
8048

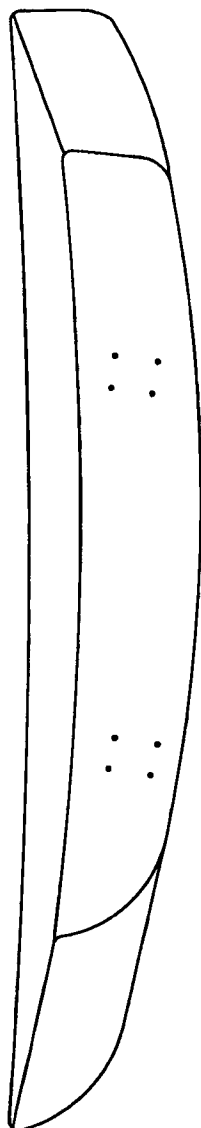
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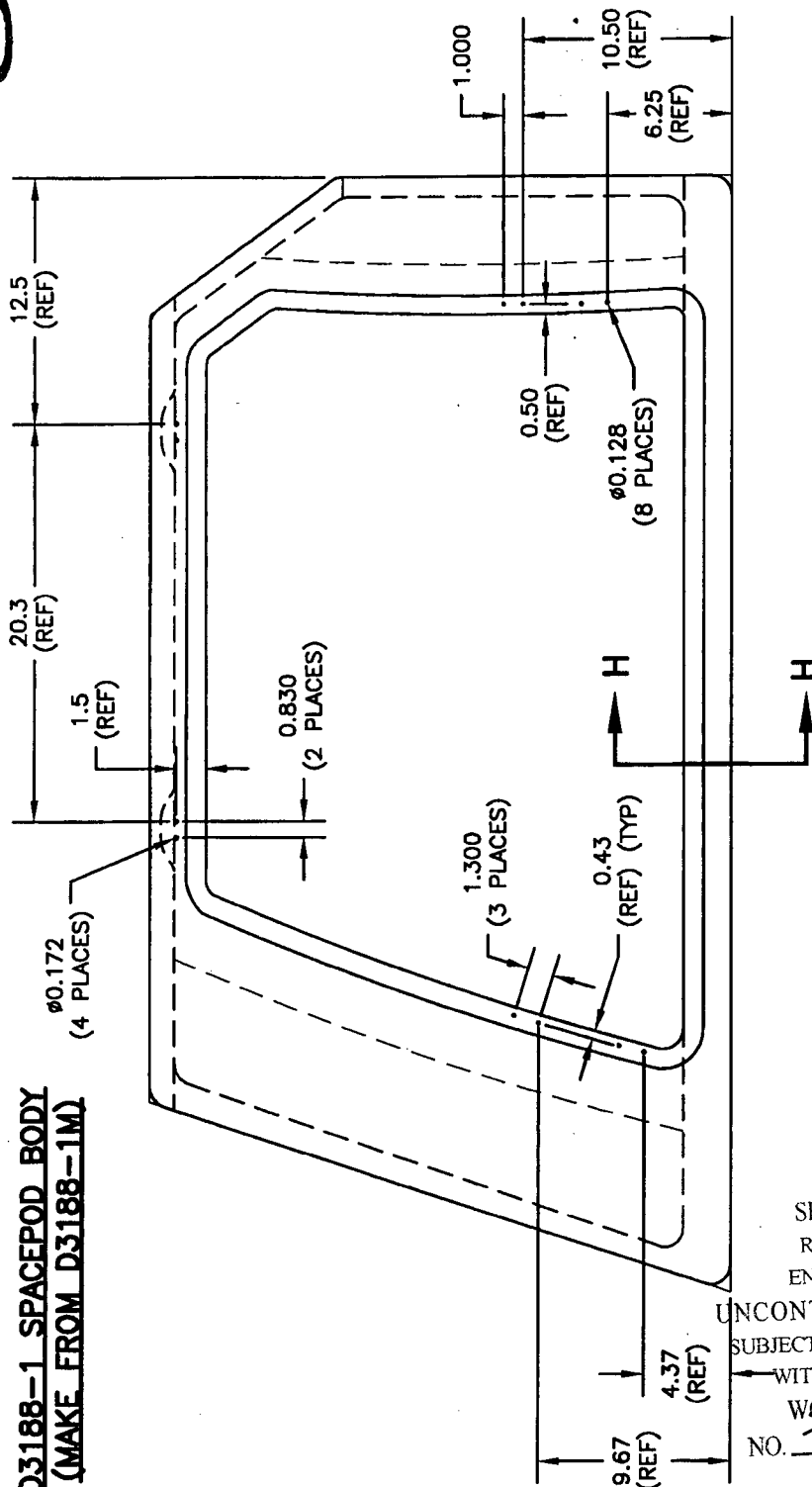


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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED
06.12.22



**D3188-1 SPACEPOD BODY
(MAKE FROM D3188-1M)**



NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEW

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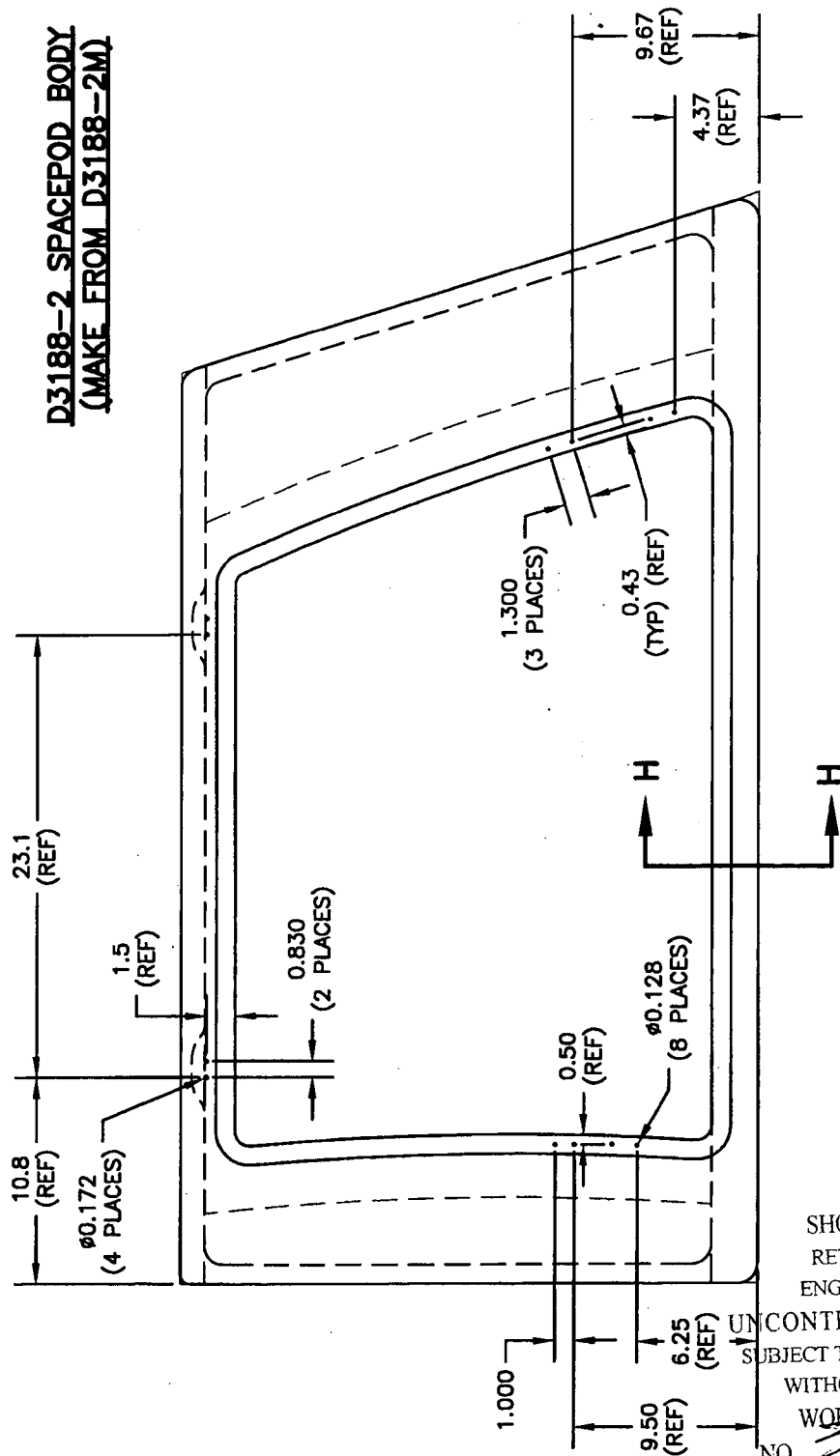
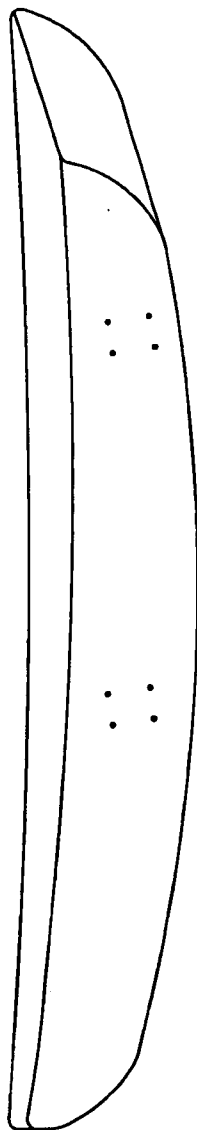
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED
06.12.22

**D3188-2 SPACEPOD BODY
(MAKE FROM D3188-2M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
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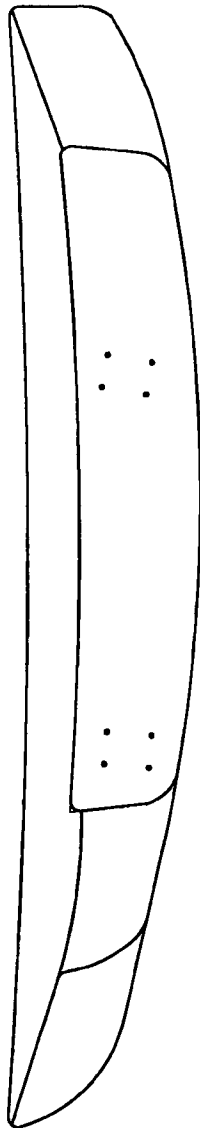
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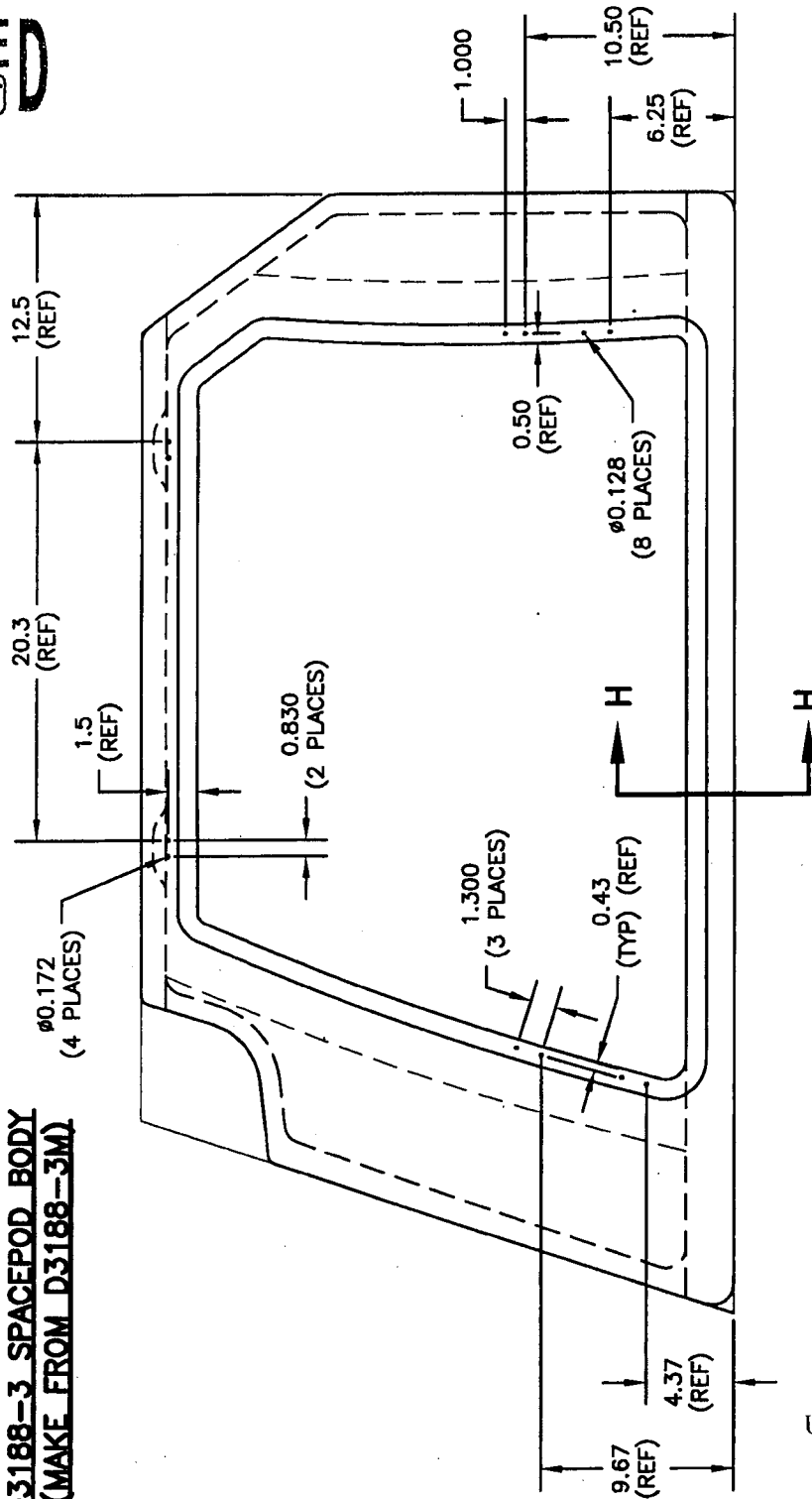


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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED
06.12.22



**D3188-3 SPACEPOD BODY
(MAKE FROM D3188-3M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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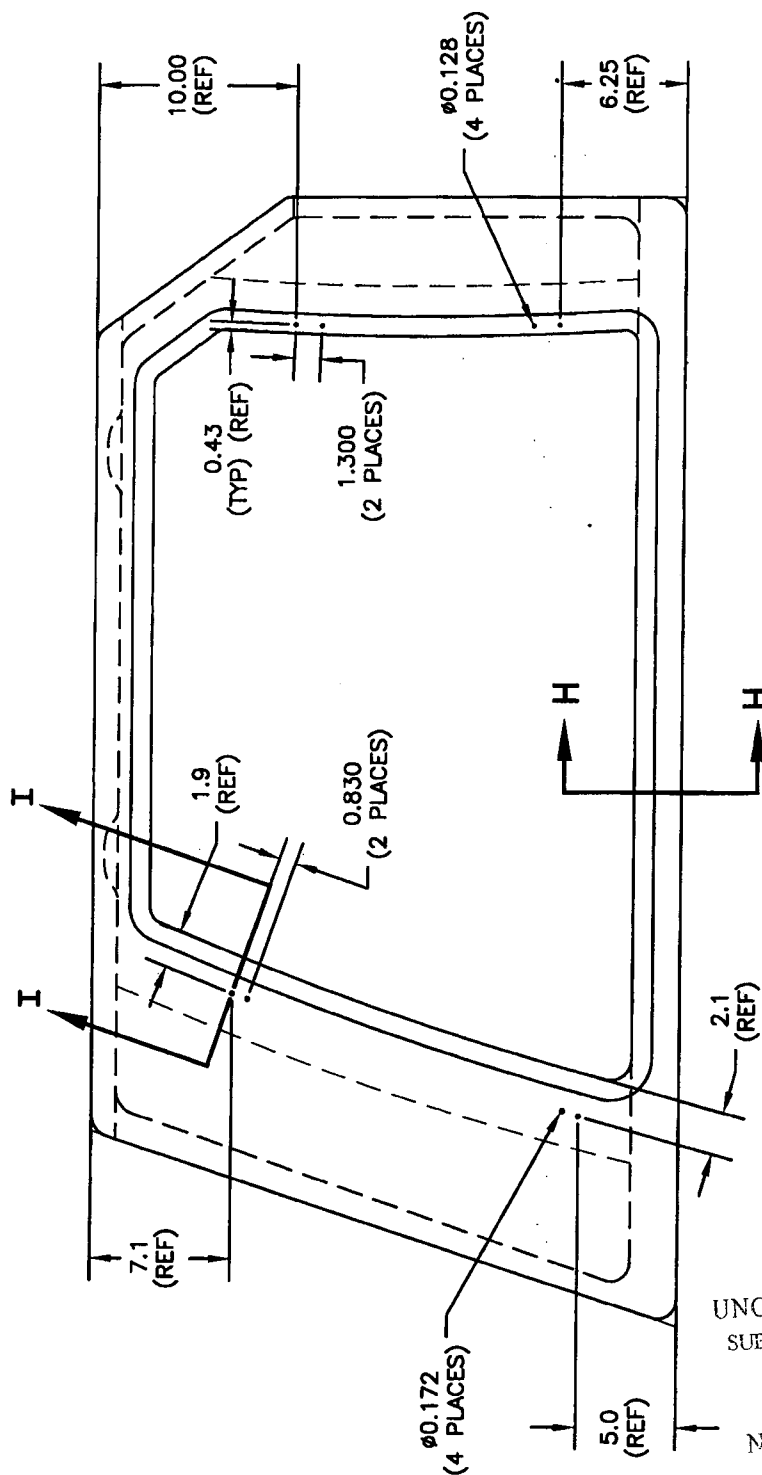
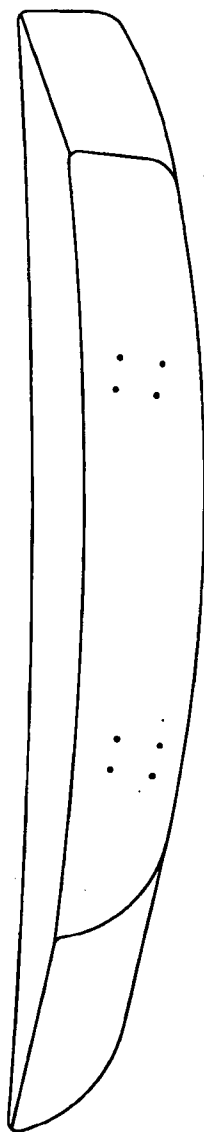
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED
06.12.22

D3188-5 SPACEPOD BODY
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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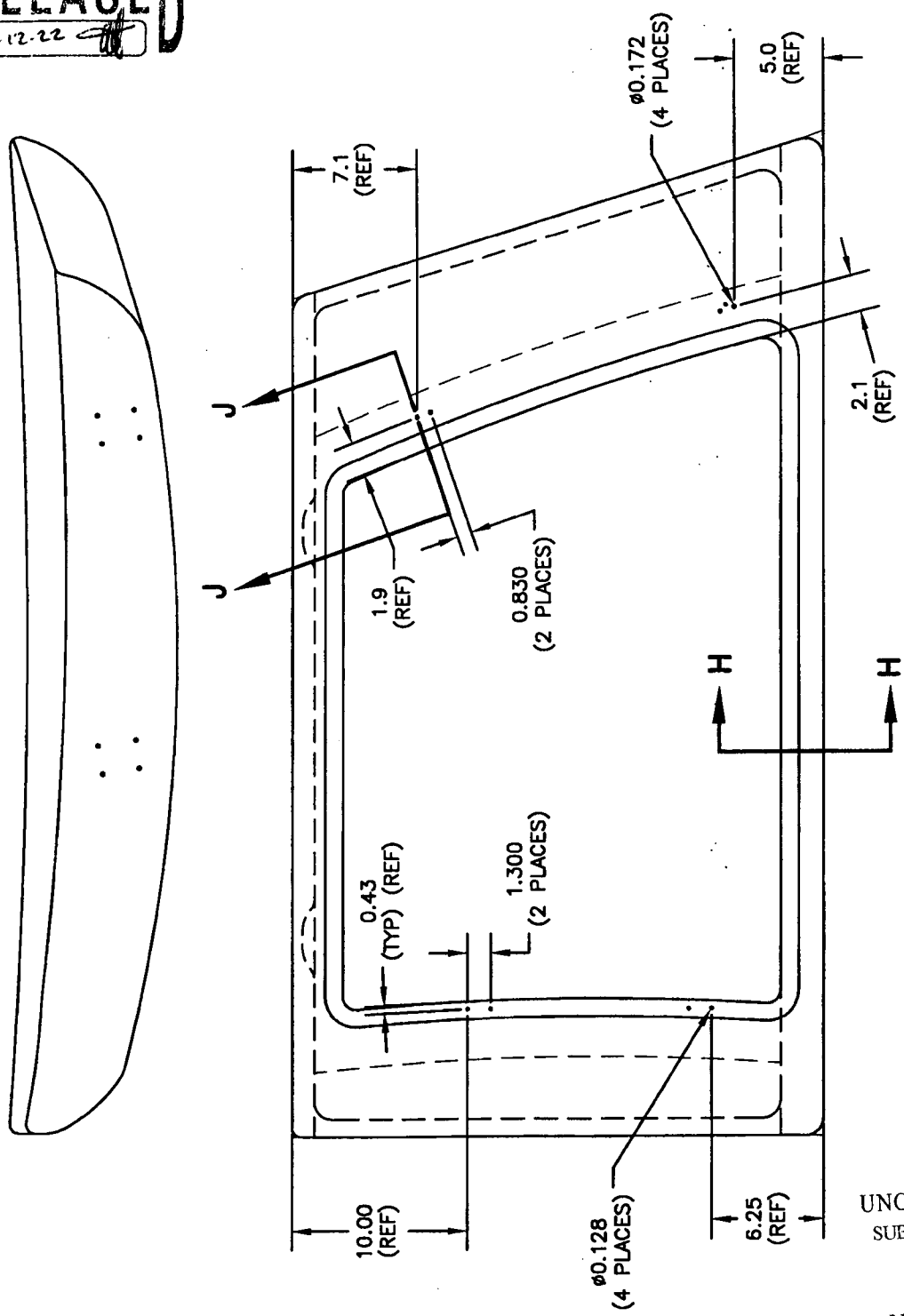
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED
06.12.22 [Signature]

D3188-6 SPACEPOD BODY
(MAKE FROM D3188-2M)



- NOTES:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
 - 2) SEE SHEET #11 FOR SECTION VIEWS

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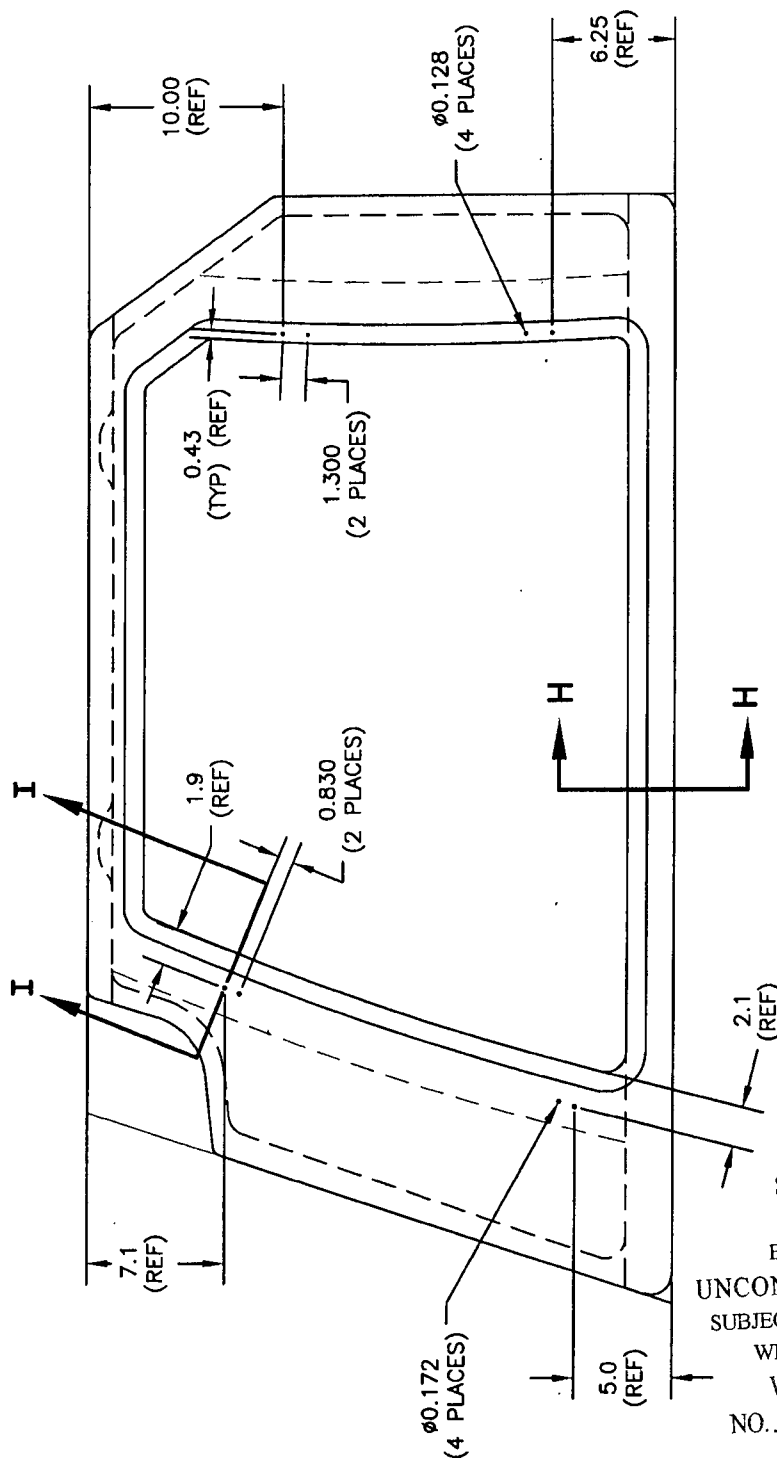
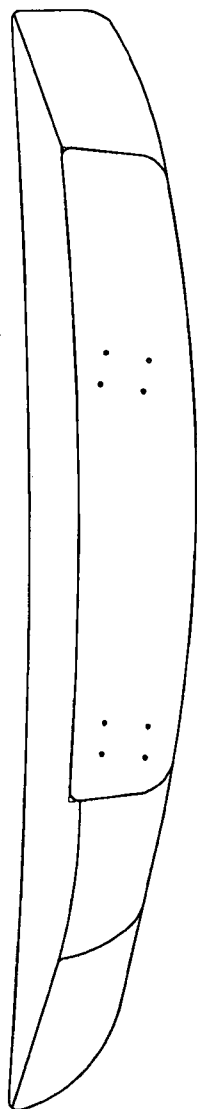
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED
a. r. r. [Signature]

D3188-7 SPACEPOD BODY
(MAKE FROM D3188-3M)



- NOTE:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
 - 2) SEE SHEET #11 FOR SECTION VIEWS

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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

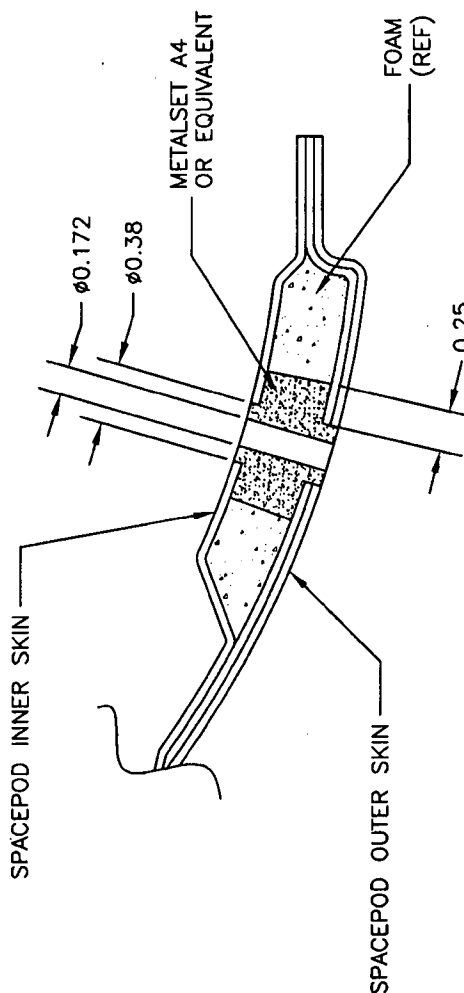
RELEASED
06.12.22

INSTALL AKS7-1032-130
INSERTS (29 PLACES)
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)

FOAM
(REF)



SECTION H-H
(TYPICAL FLOOR SECTION)



SECTION I-I
(SECTION J-J OPPOSITE)
(4 PLACES PER POD)

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Date: Wednesday, 3/7/2007 4:33:49 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACEPOD DOOR RH
Job Number : 31083C	
Estimate Number : 12636	
P.O. Number :	Part Number : D31864
This Issue : 3/7/2007 S.O. No. :	Drawing Number : D3186 REV.D
Prsht Rev. : NC	Project Number : N/A
First Issue : 3/7/2007 Type : SMALL /MED FAB	Drawing Revision : D
Previous Run :	Material :
Written By : <u> </u>	Due Date : 3/30/2007 Qty: 1 Um: Each
Checked & Approved By : <u> </u>	
Comment : Est Rev. A New Issue 07-01-11 EC	
est rev.B revD 07.03.07 ec	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

31083C01

SPACEPOD DOOR RH



Comment: Sub-Component SPACEPOD DOOR RH

D3186 2M (M 30038)

2.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



PTO

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill holes and cut out slots for latch as per dwg D3186 (D3186-4 detail)

ml 07/03/07

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2004.05

4.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

31083

5.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U of 07-01-05

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/16	2	Install tap Hinge (D2857-1) to high Have 2 Holes to High The 2 other are good	Q51042	Verify hinge location before drilling. Fill the top holes with Resin 9309 NA B M101268 mix with mill fiber B M100859	ml 07/03/20		Q51042	07-03-16
---	---	Top holes went through the edge of the foam core. Human error.	Q51042	Sand Area smooth: ensure there are no pin holes. AS per Q510379.1 Touch up area as necessary with grey primer. AS per Q51005.	ml 07/03/20		Q51042	07-03-16

NOTE: Date & initial all entries

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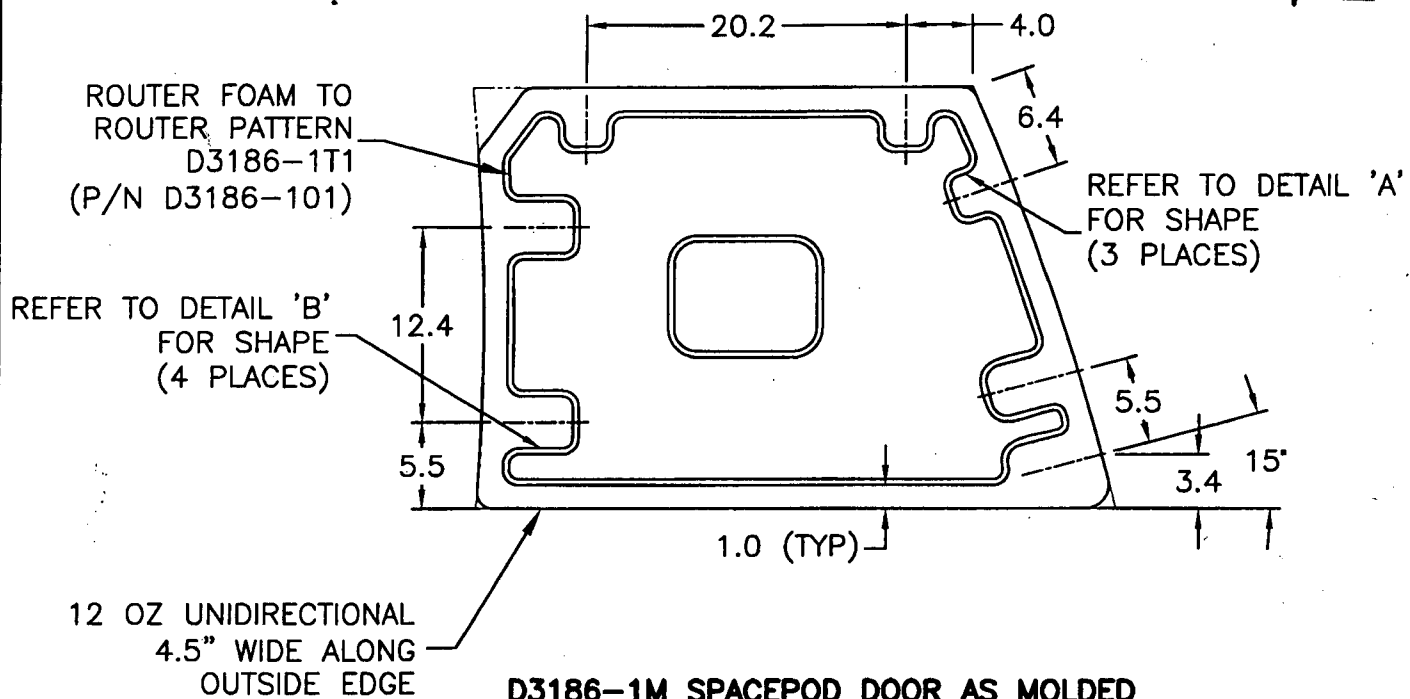
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CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27

**D3186-1M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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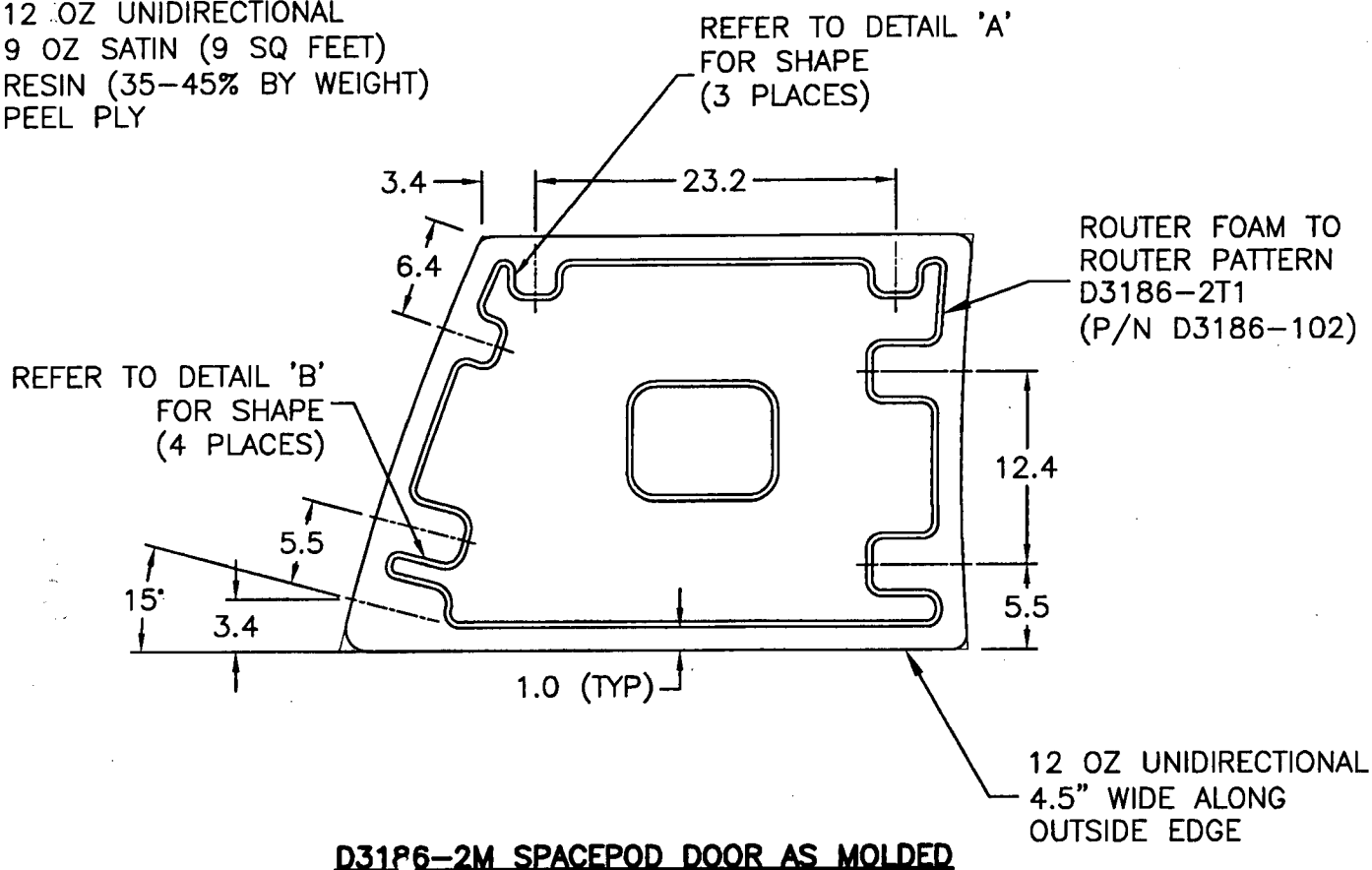
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED07.02.27 *H***D3186-2M SPACEPOD DOOR AS MOLDED**NOTES:

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
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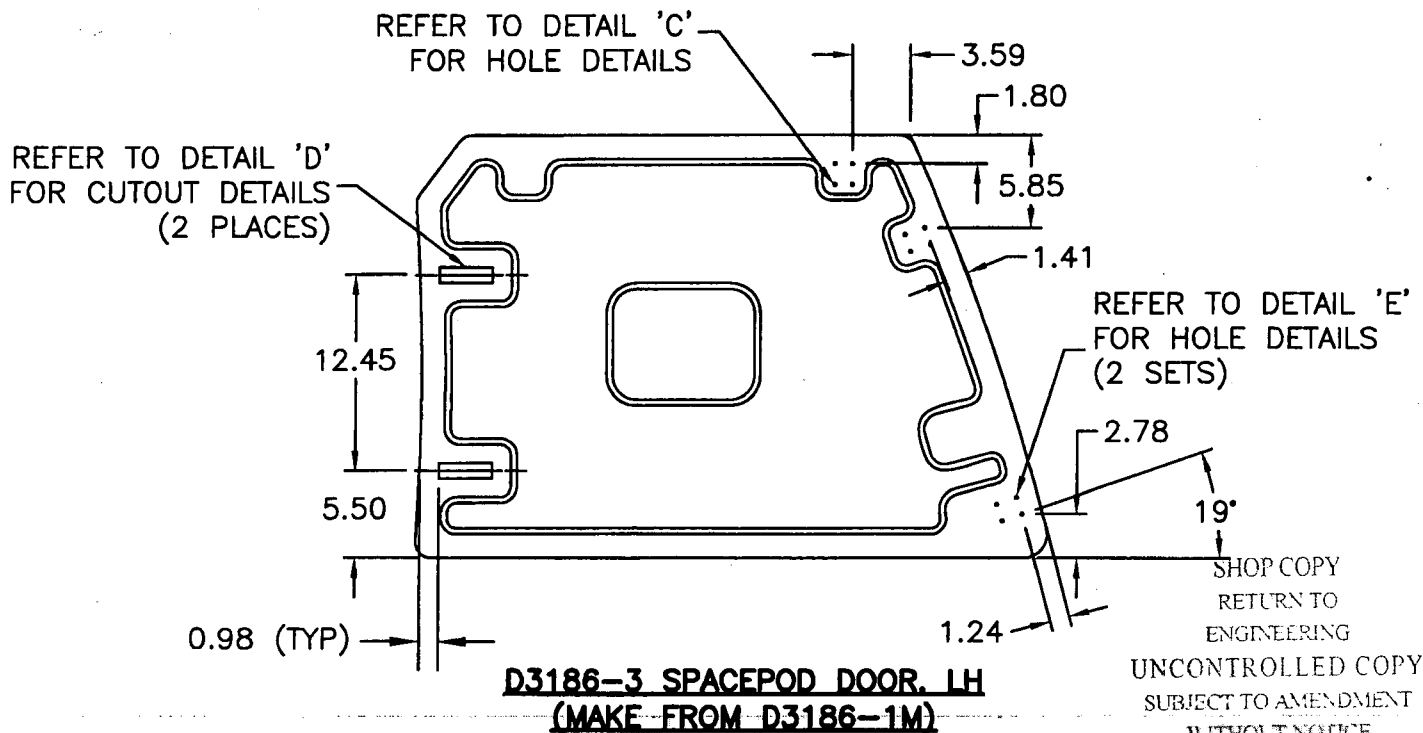
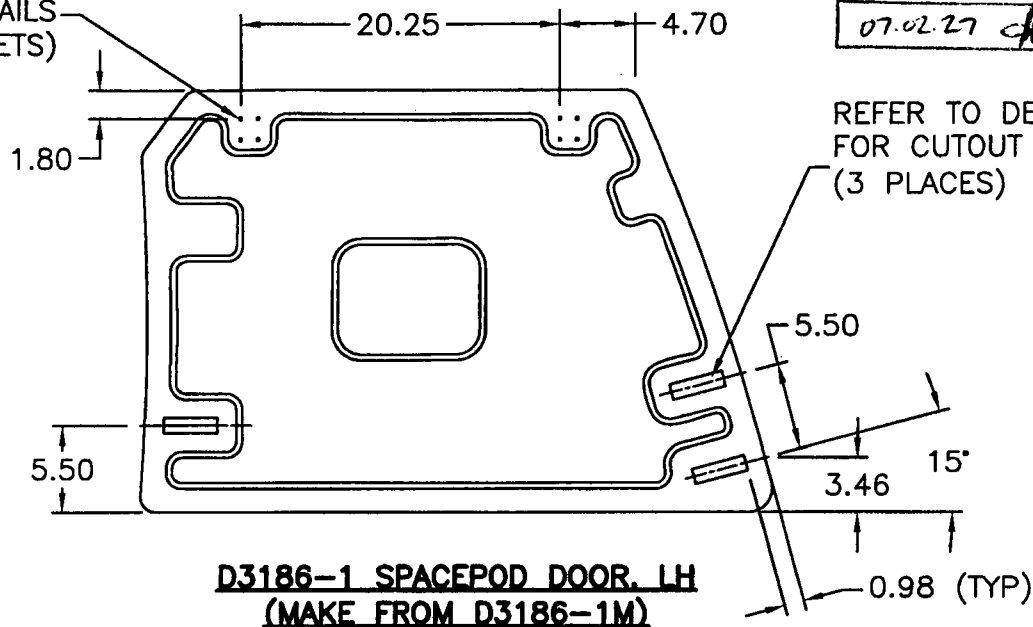
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

REFER TO DETAIL 'C'
FOR HOLE DETAILS
(2 SETS)

**NOTES:**

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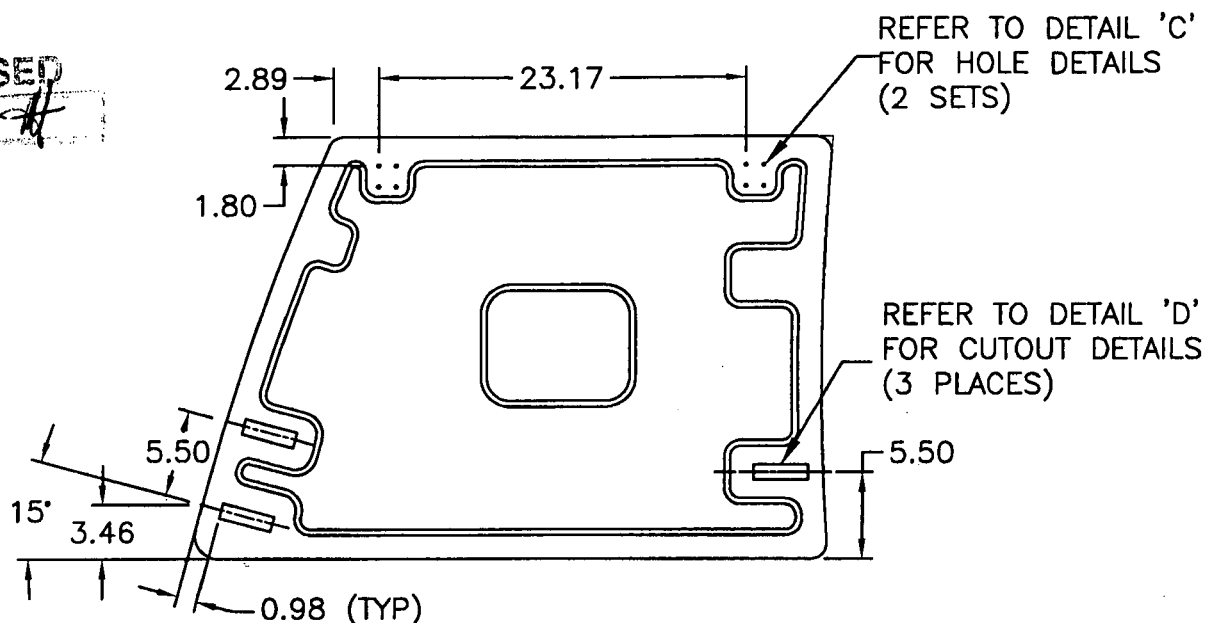
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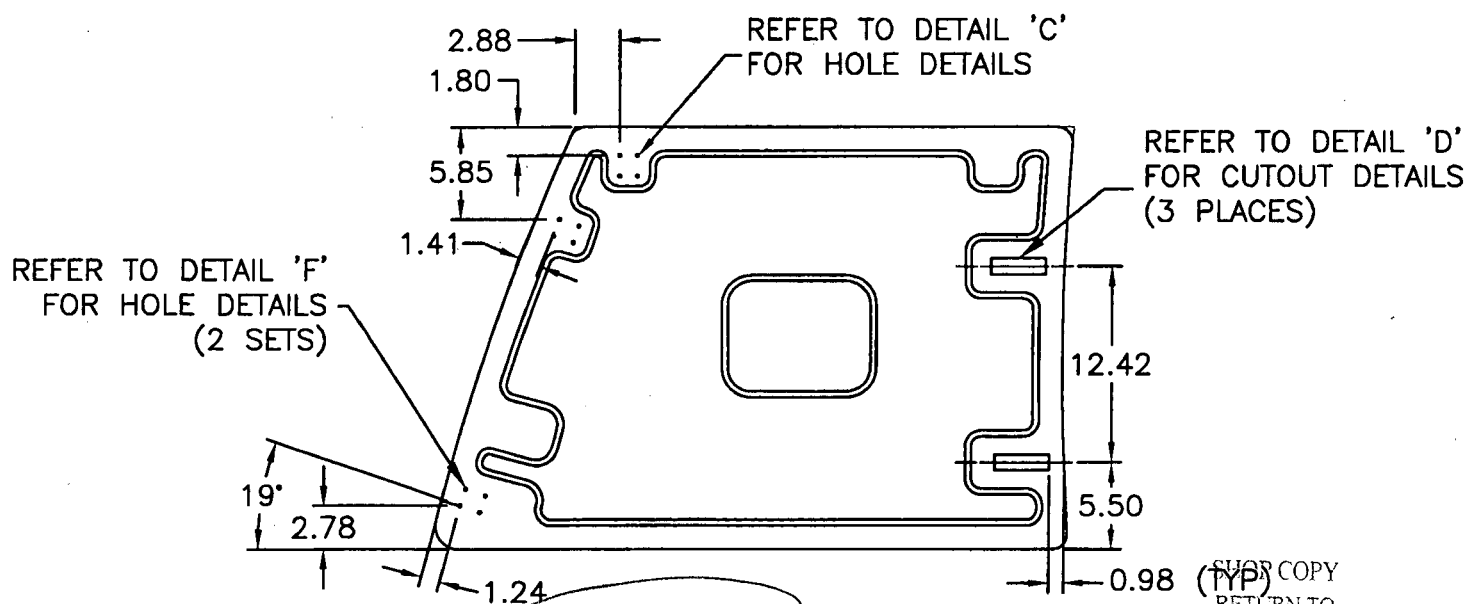


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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

RELEASED
07-02-27



D3186-2 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)

NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
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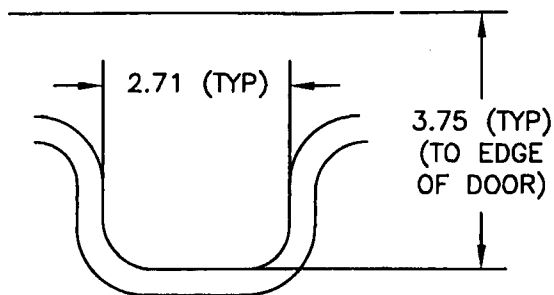
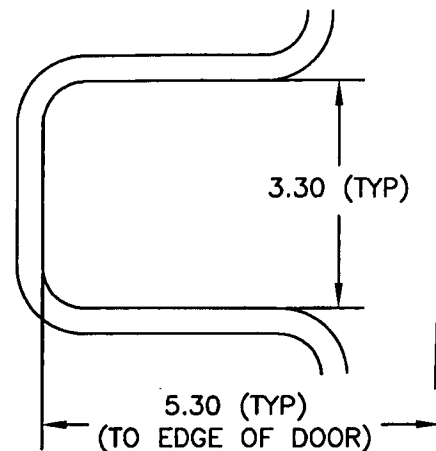
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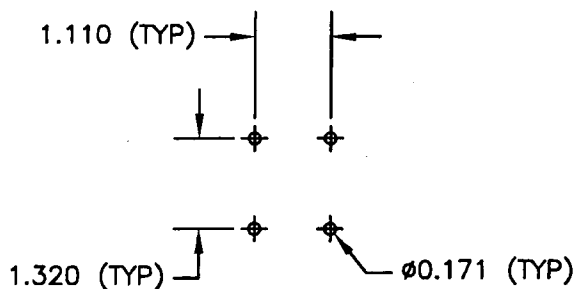
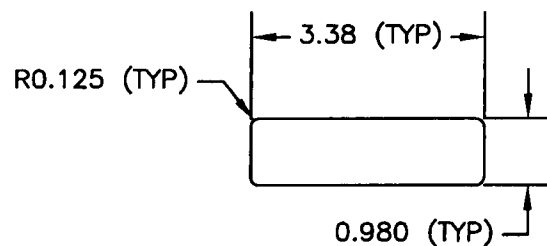
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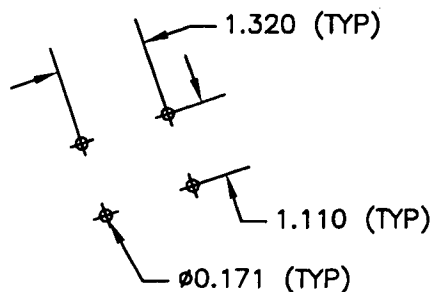
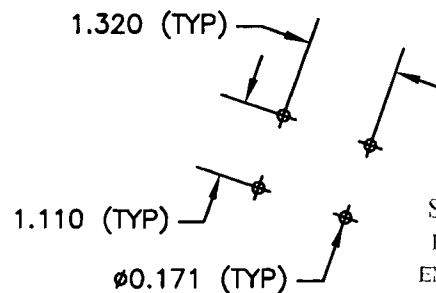
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

**DETAIL A****DETAIL B****RELEASED**

07.02.27 [Signature]

**DETAIL C**

NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D**DETAIL E****DETAIL F**

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